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(71) Applicant: **Apple Inc.**, Cupertino, CA (US)(72) Inventors: **George Tziviskos**, San Jose, CA (US);
Paul J. Hack, San Jose, CA (US);
Samuel W. Yuen, Markham (CA);
Nathan N. Ng, Fremont, CA (US);
Zheng Gao, Sunnyvale, CA (US);
Mahmoud R. Amini, Sunnyvale, CA (US);
Min Chul Kim, Santa Clara, CA (US);
Colin J. Abraham, Mountain View, CA (US)(73) Assignee: **Apple Inc.**, Cupertino, CA (US)(21) Appl. No.: **15/954,425**(22) Filed: **Apr. 16, 2018****Publication Classification**(51) **Int. Cl.**

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H01R 13/627	(2006.01)

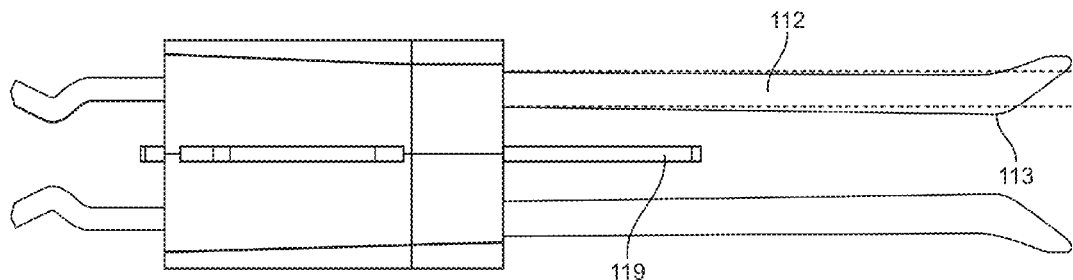
(52) **U.S. Cl.**CPC **H01R 24/70** (2013.01); **H01R 13/6597** (2013.01); **H01R 13/6585** (2013.01); **H01R 43/16** (2013.01); **H01R 13/6275** (2013.01); **Y10T 29/4921** (2015.01); **H01R 24/64** (2013.01); **H01R 13/2442** (2013.01); **H01R 13/6581** (2013.01)**Related U.S. Application Data**

(63) Continuation-in-part of application No. 15/368,691, filed on Dec. 5, 2016, now Pat. No. 9,948,042, which is a continuation of application No. 14/641,375, filed on Mar. 7, 2015, now Pat. No. 9,515,439, which is a continuation-in-part of application No. 14/543,803, filed on Nov. 17, 2014, now Pat. No. 9,490,581.

(57)

ABSTRACT

Connector inserts having retention features with good reliability and holding force. These connector inserts may include ground contacts that provide an insertion portion having a reduced length. These connector inserts may be reliable, have an attractive appearance, and be readily manufactured.



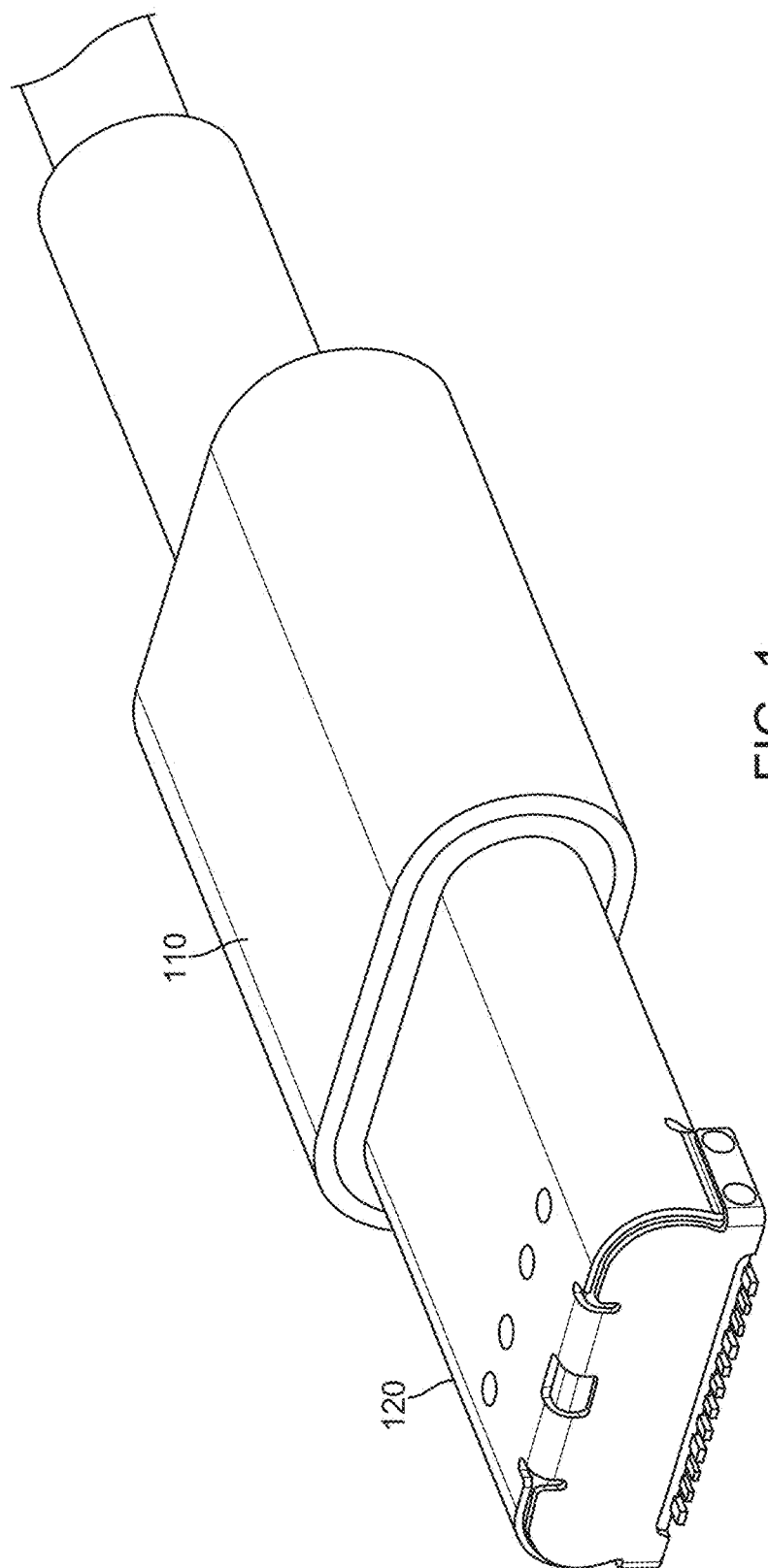


FIG. 1

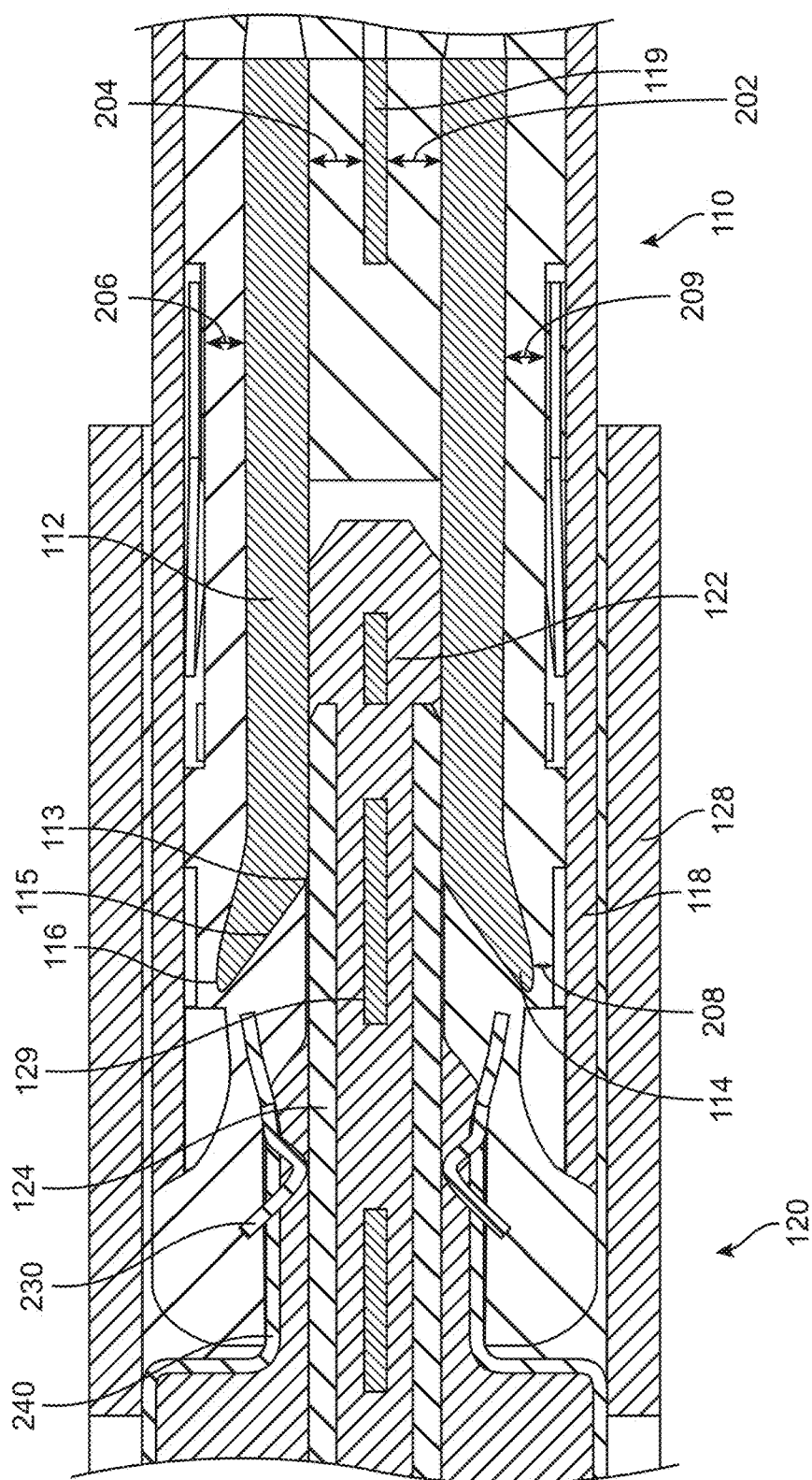


FIG. 2

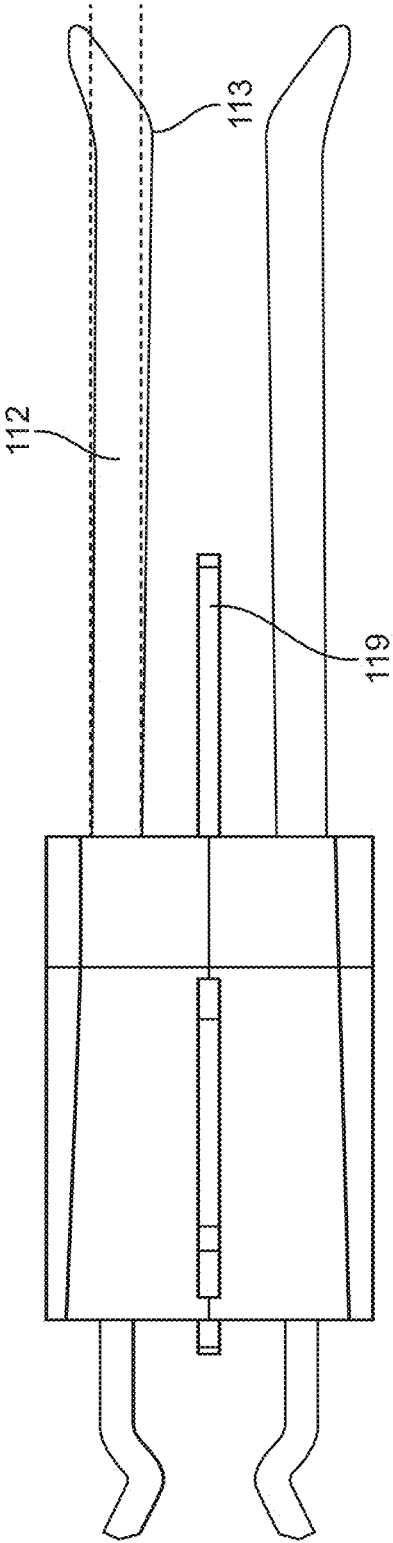


FIG. 3

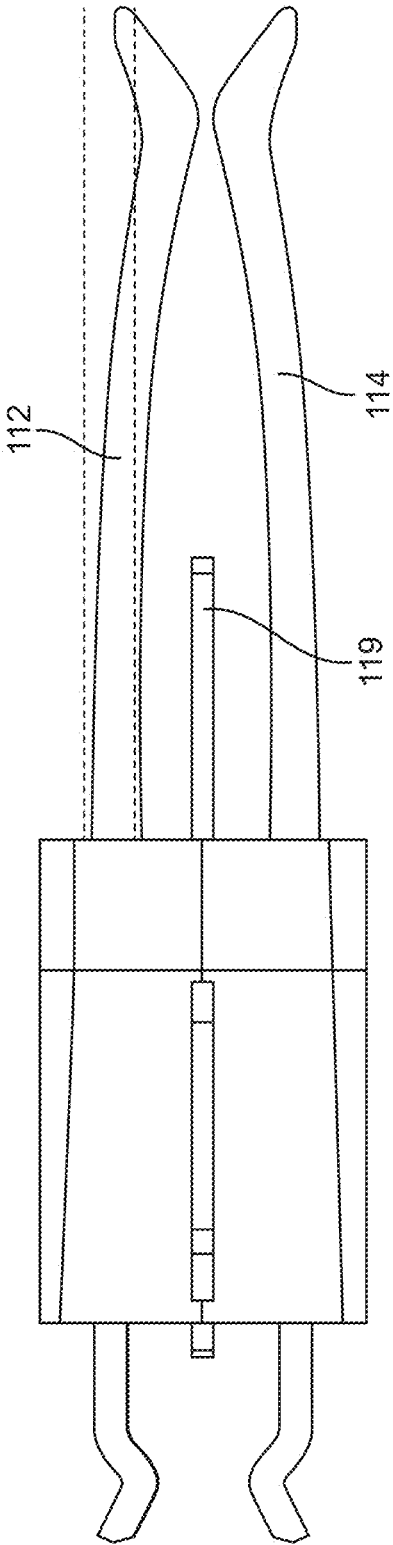
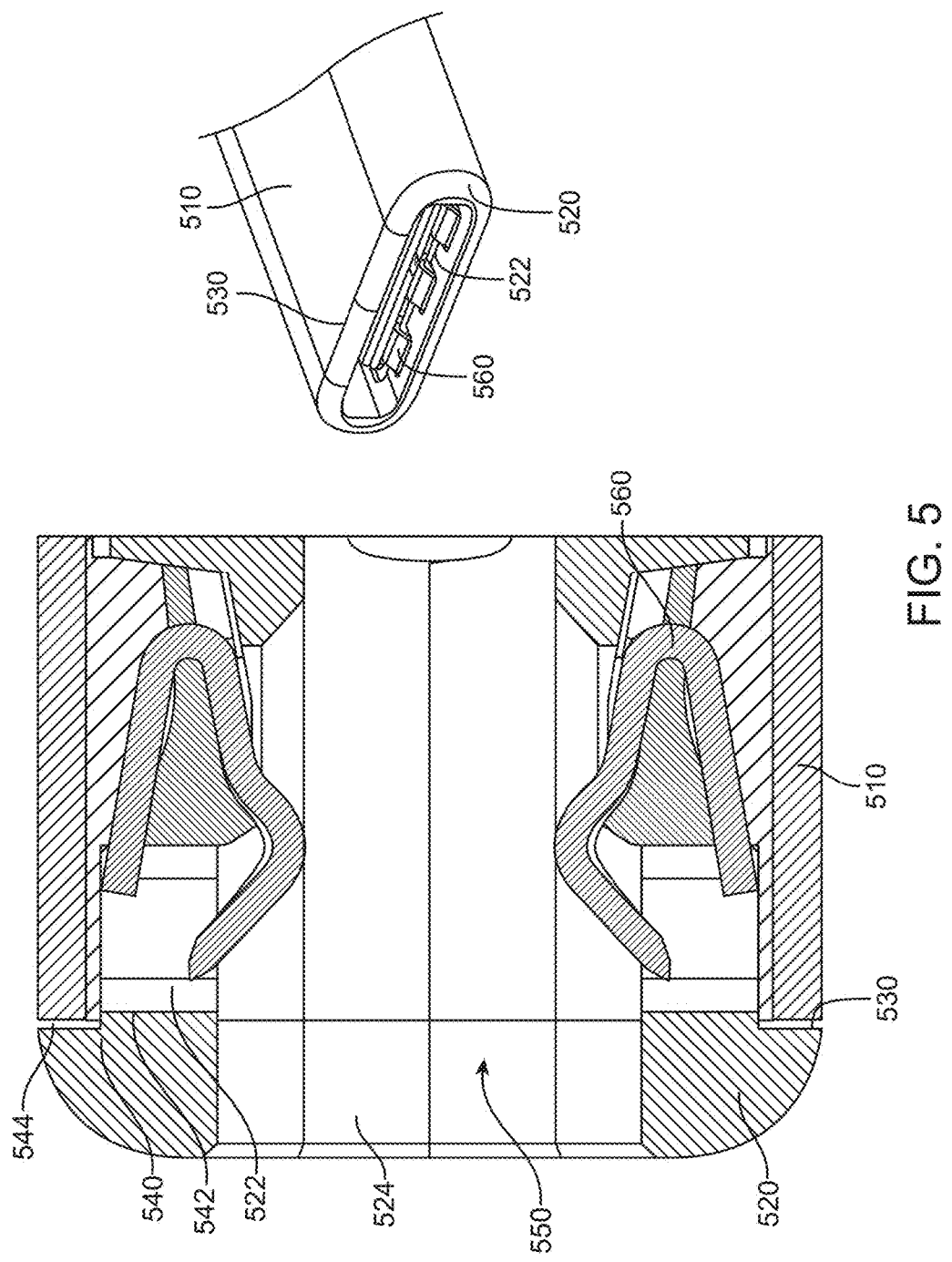


FIG. 4



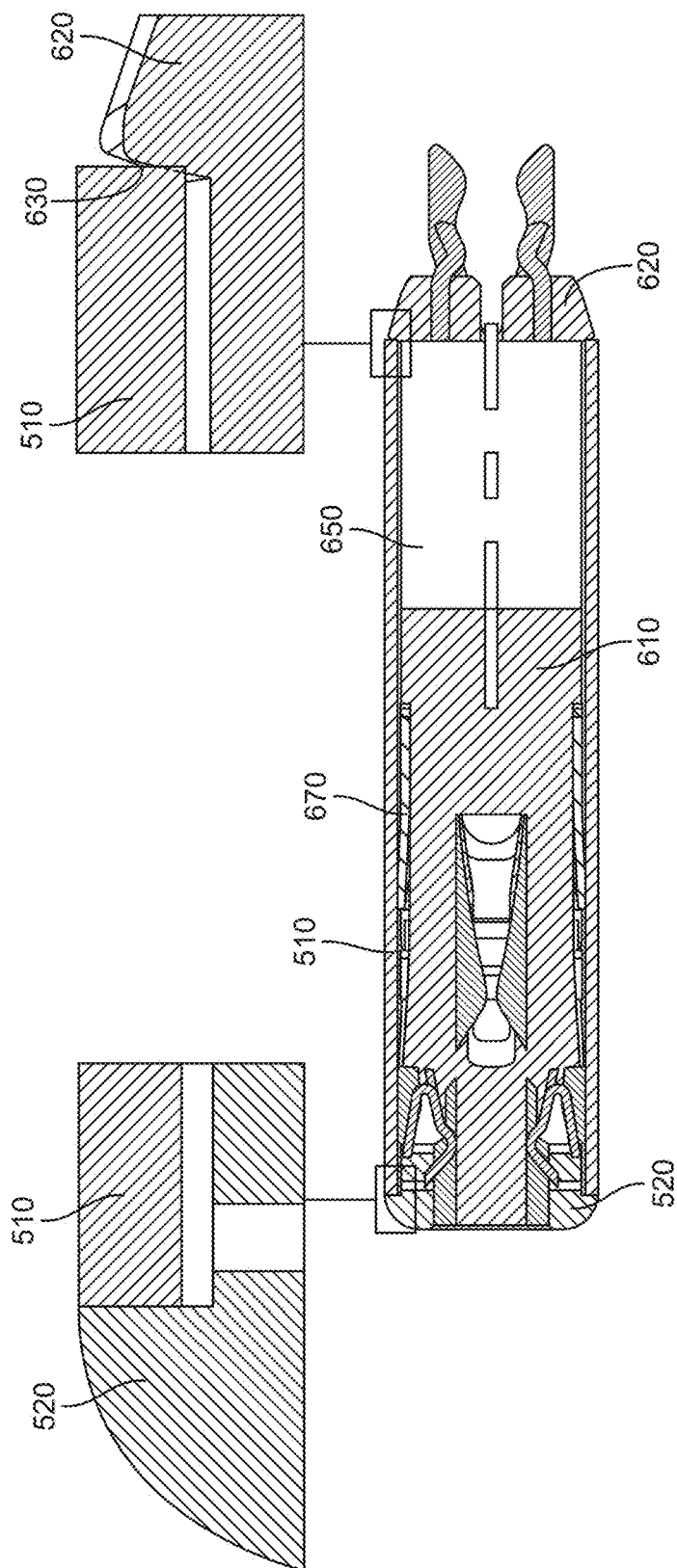


FIG. 6

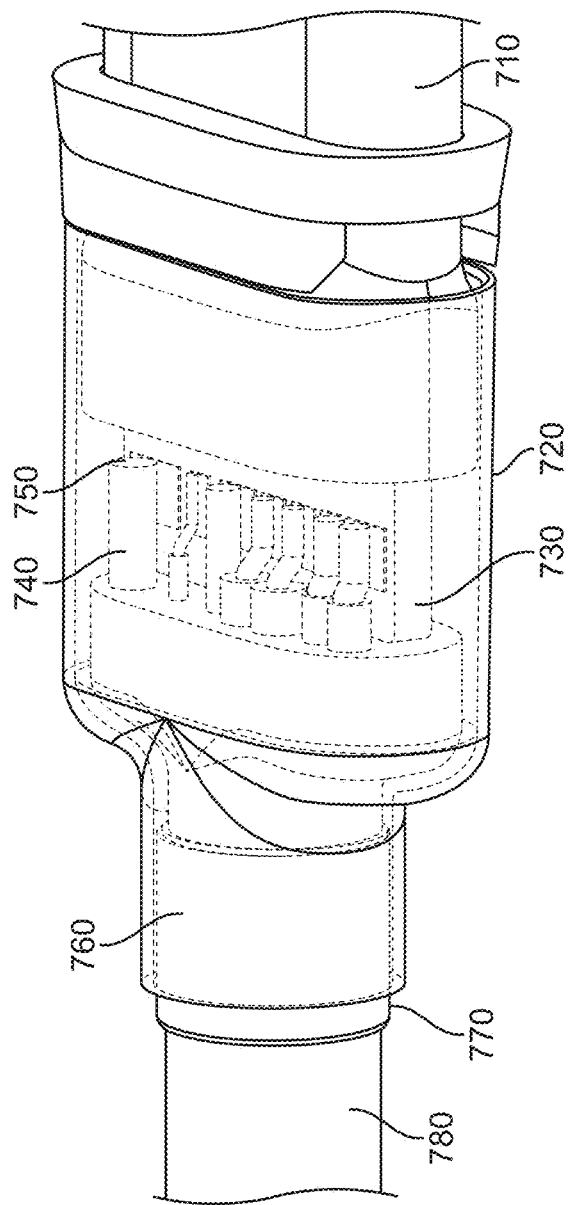


FIG. 7

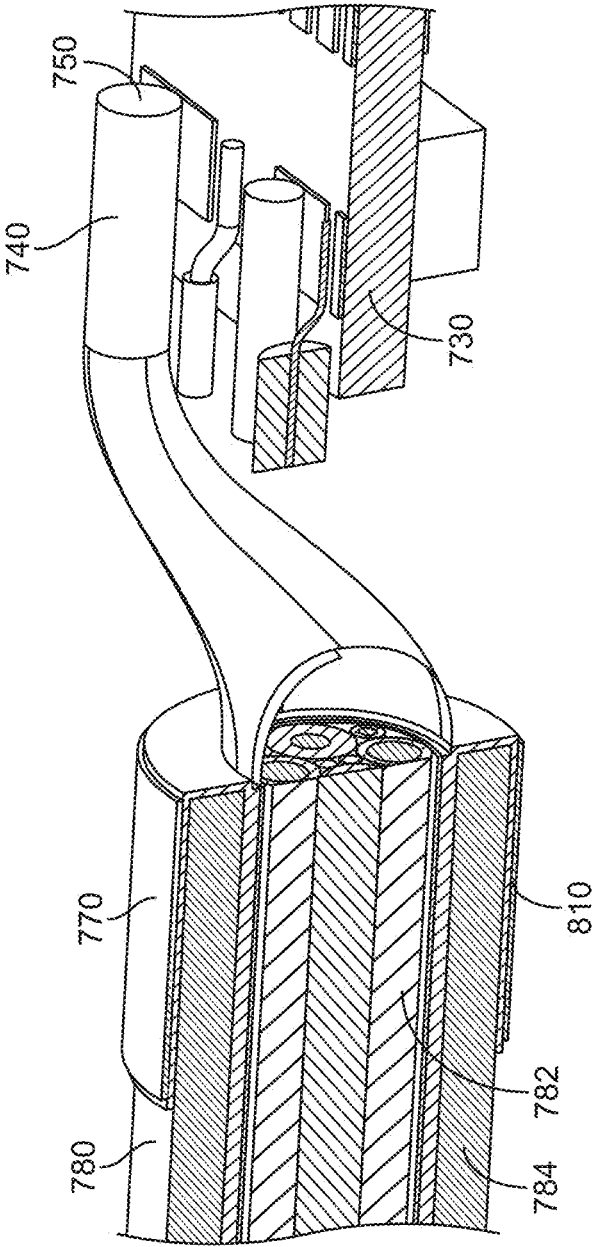


FIG. 8

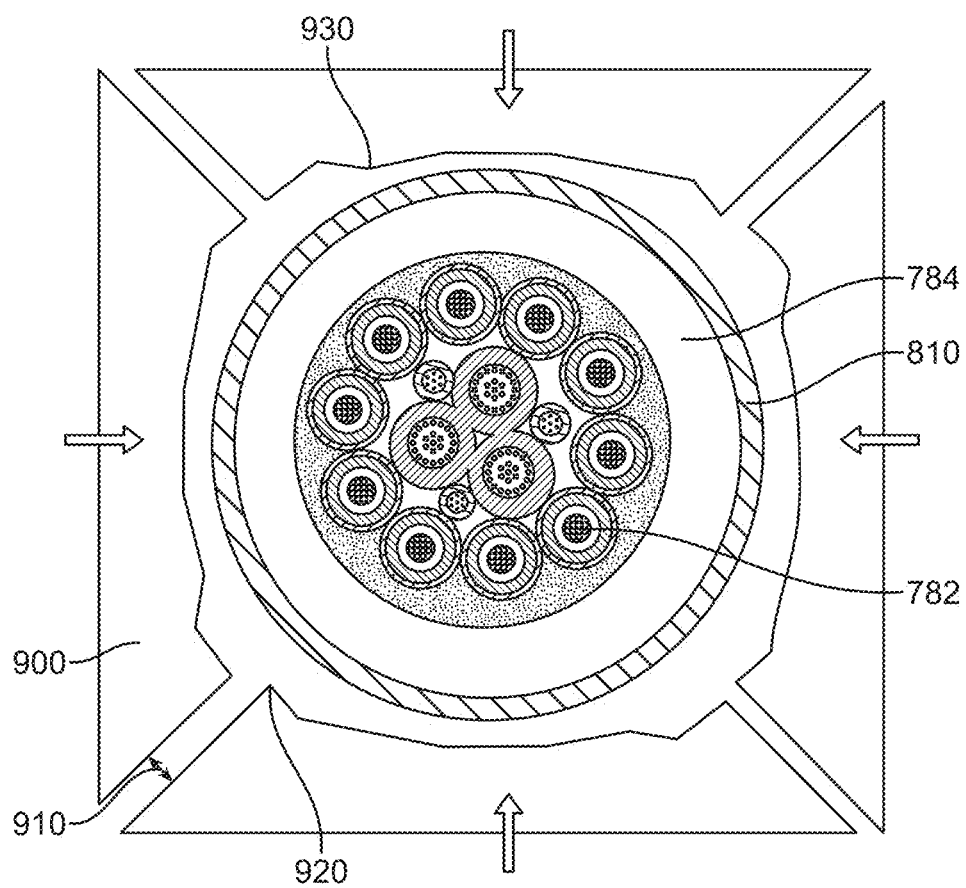


FIG. 9

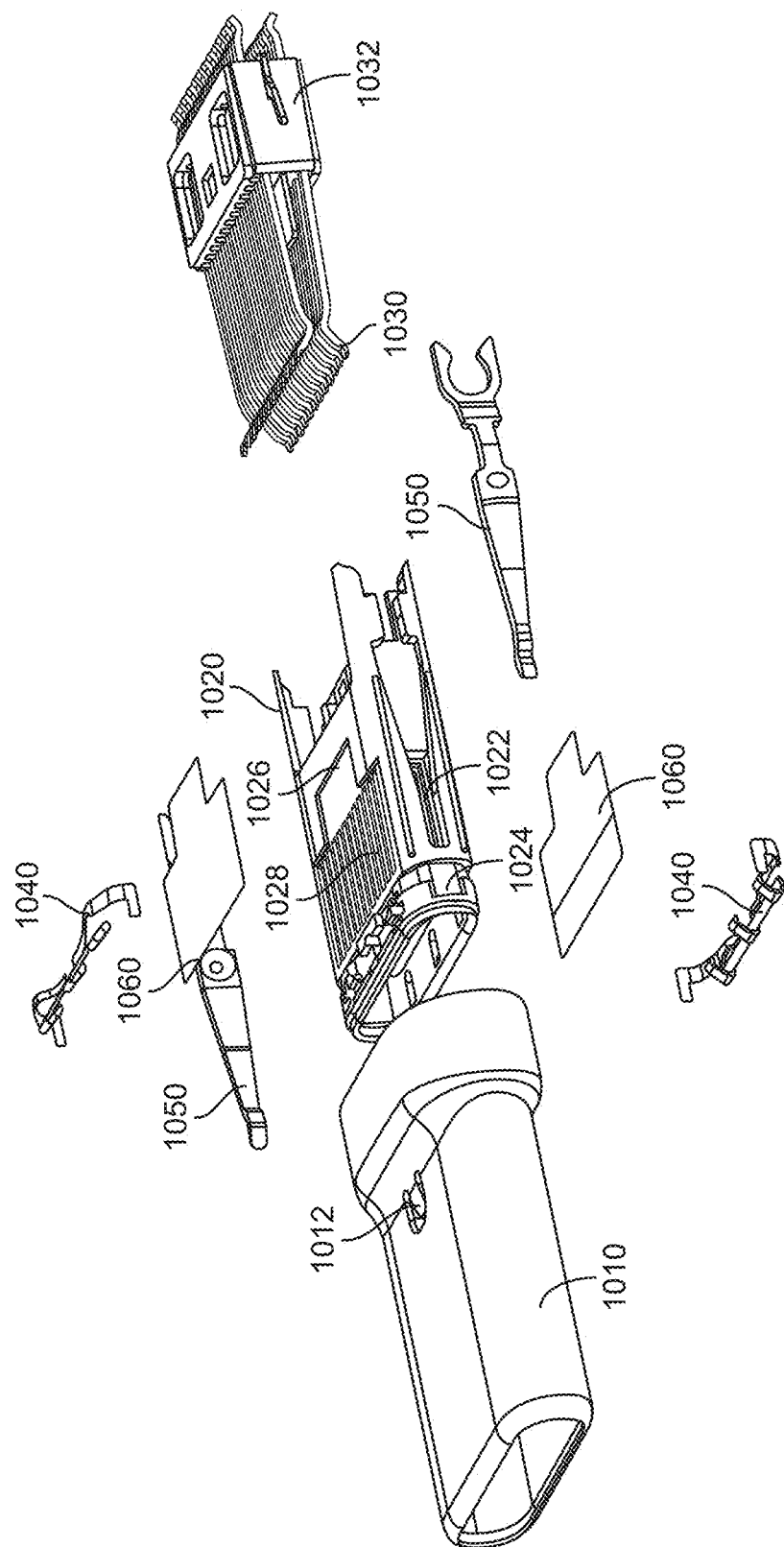


FIG. 10

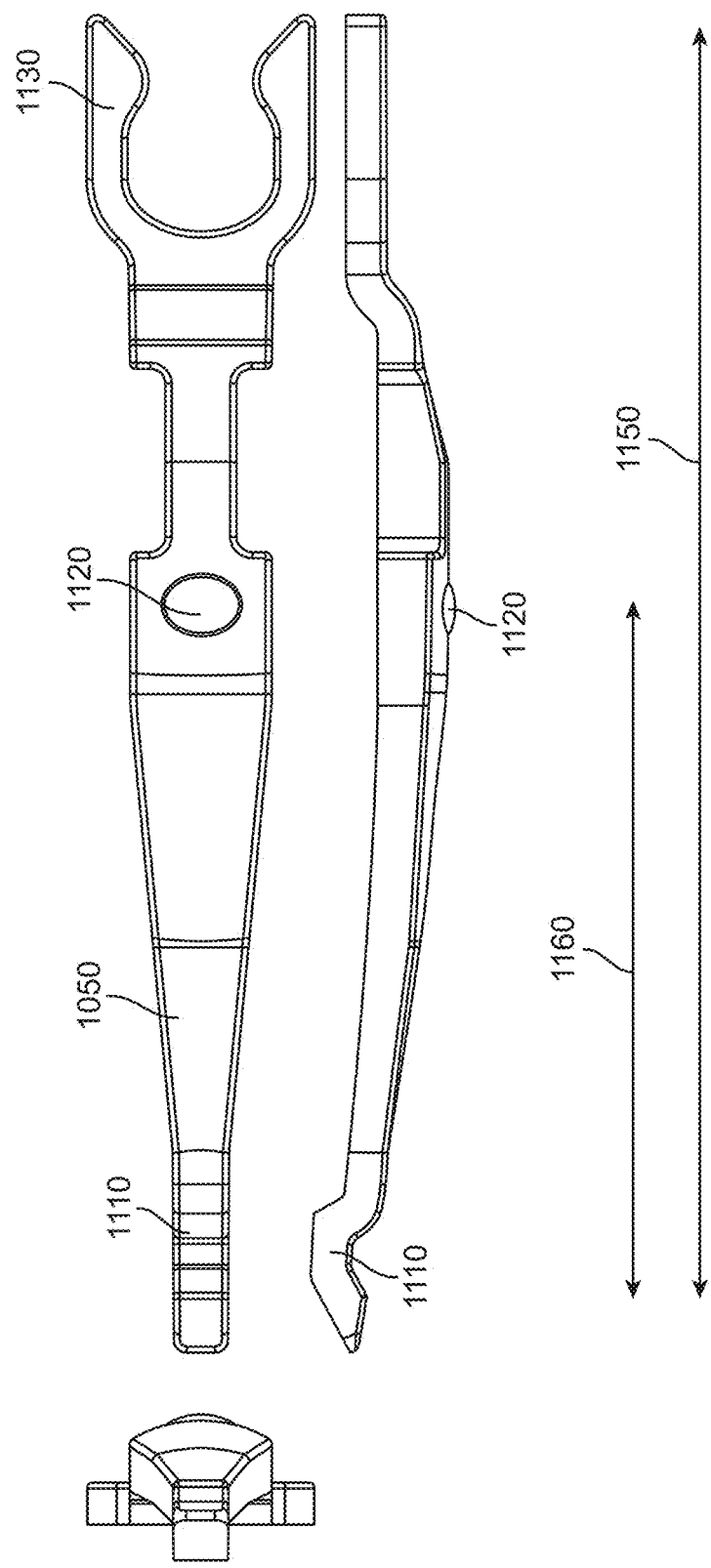


FIG. 11

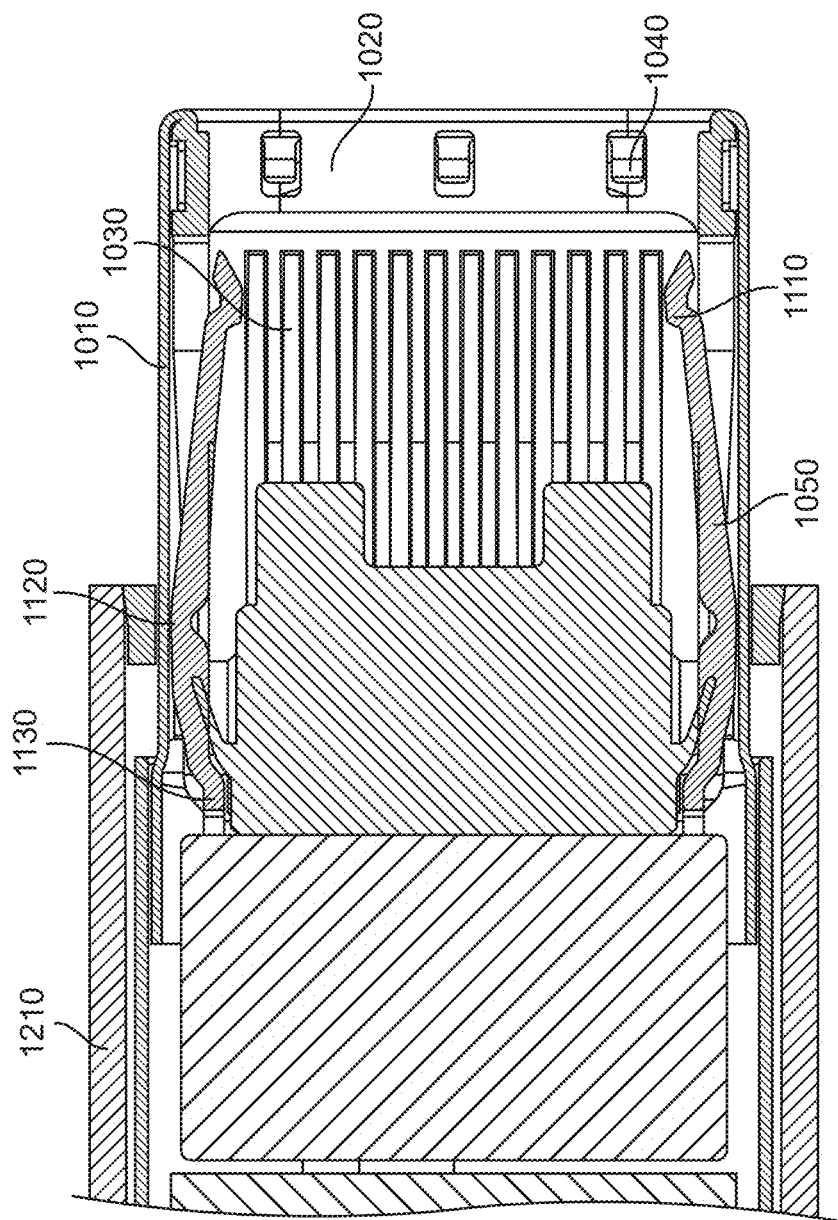


FIG. 12

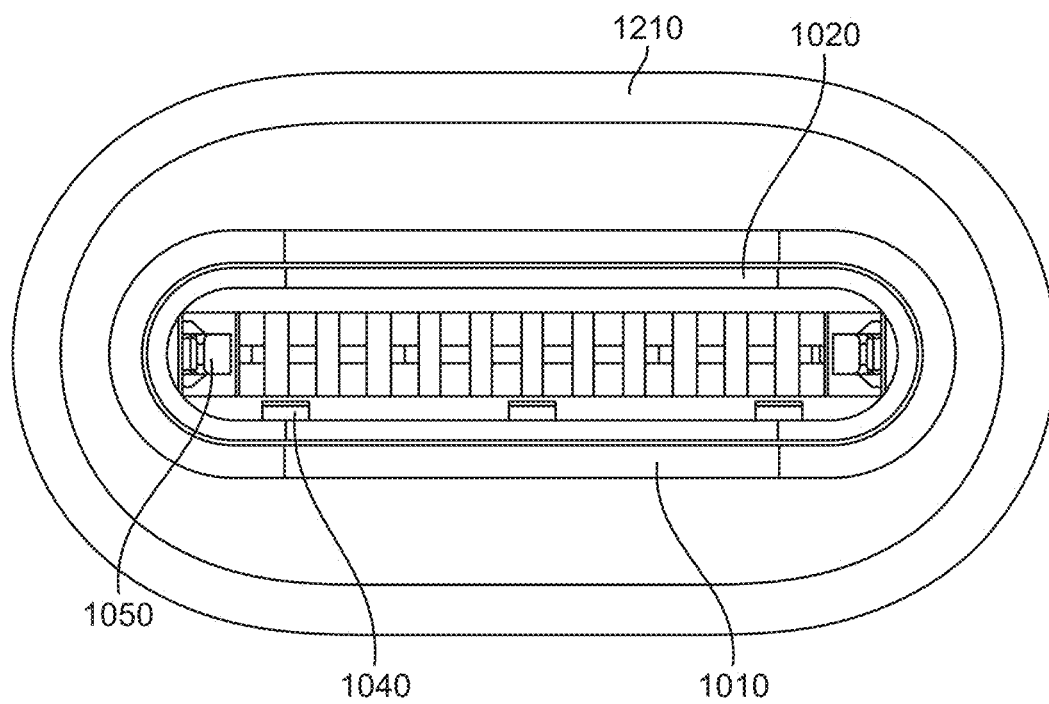


FIG. 13

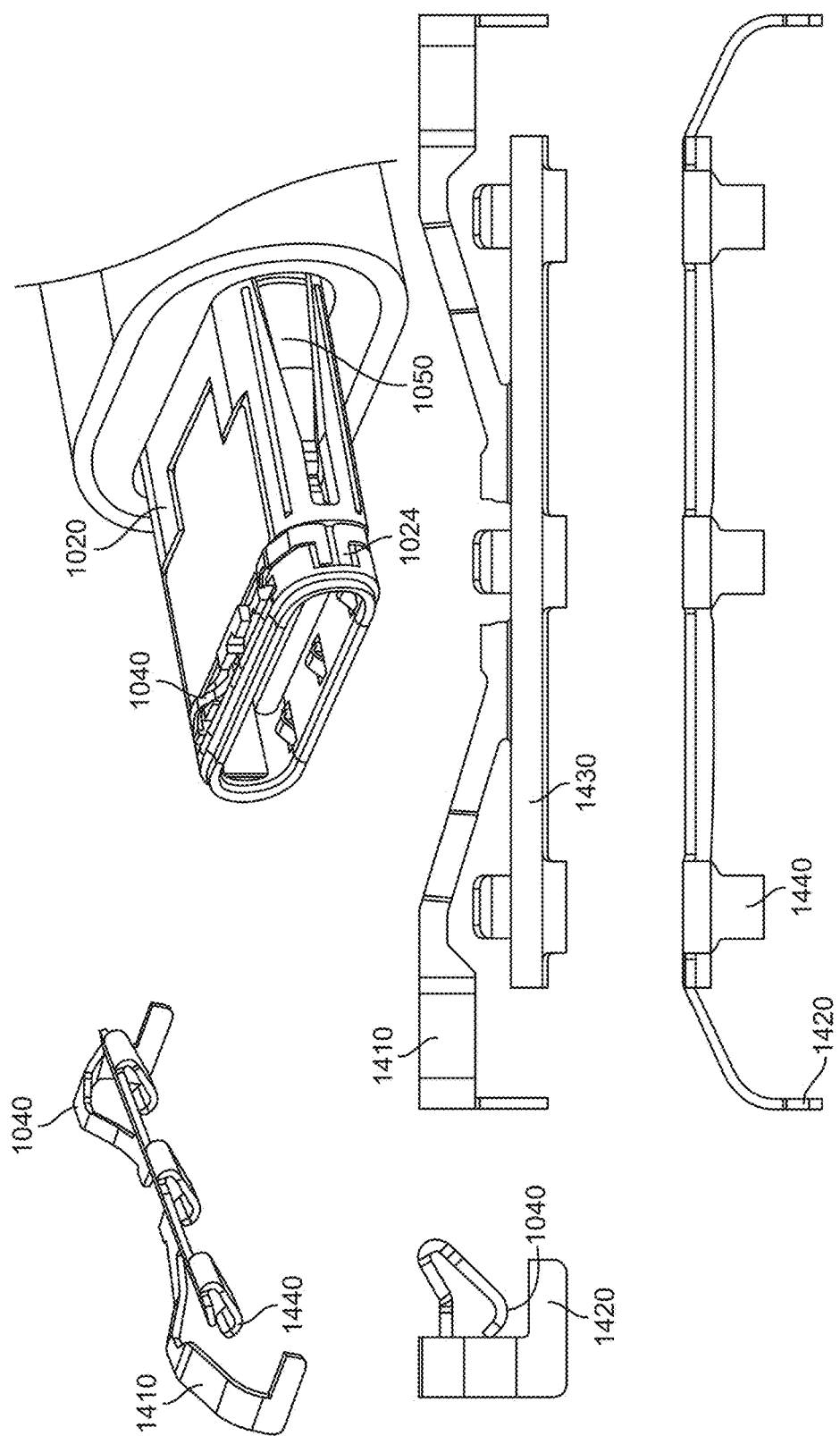


FIG. 14

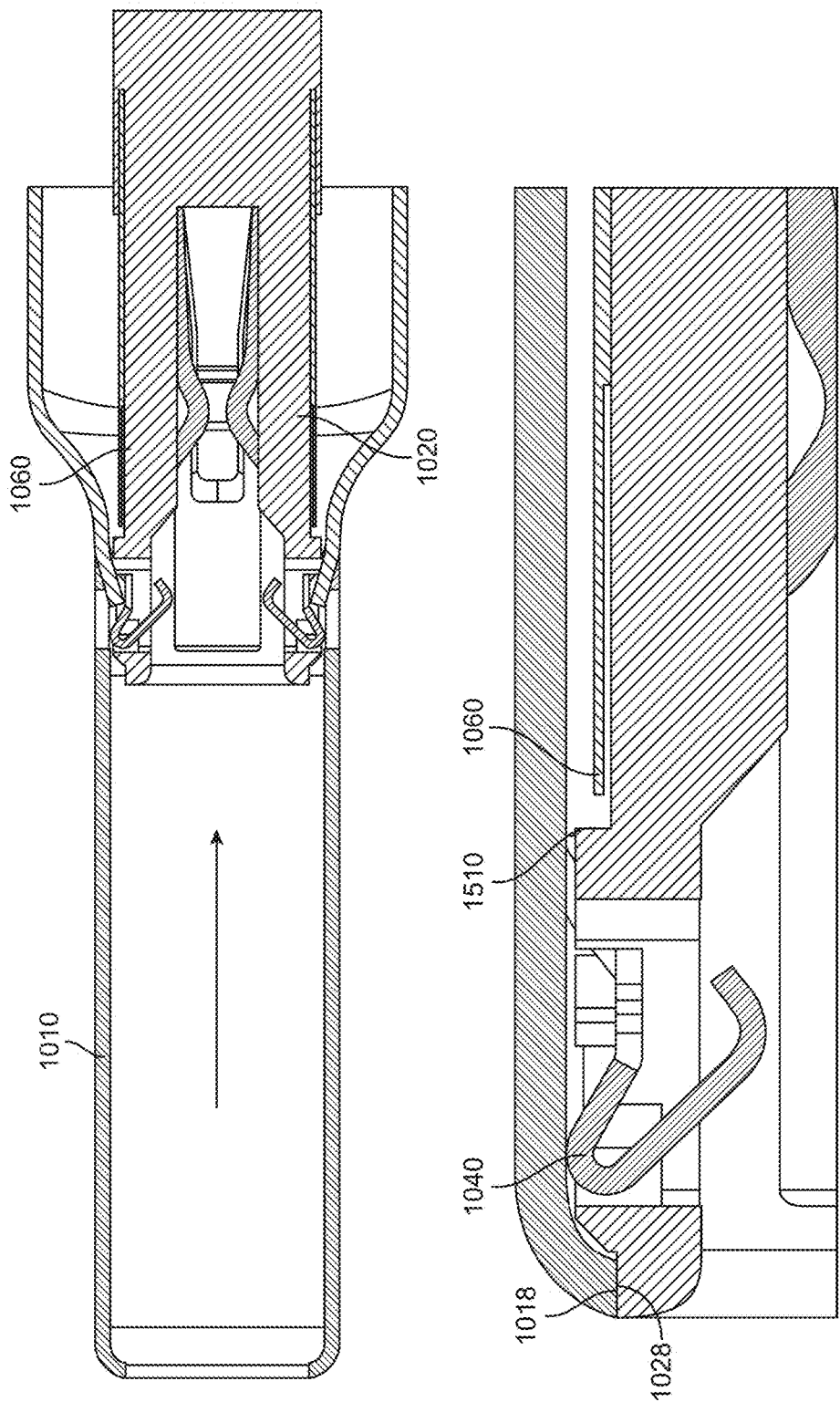


FIG. 15

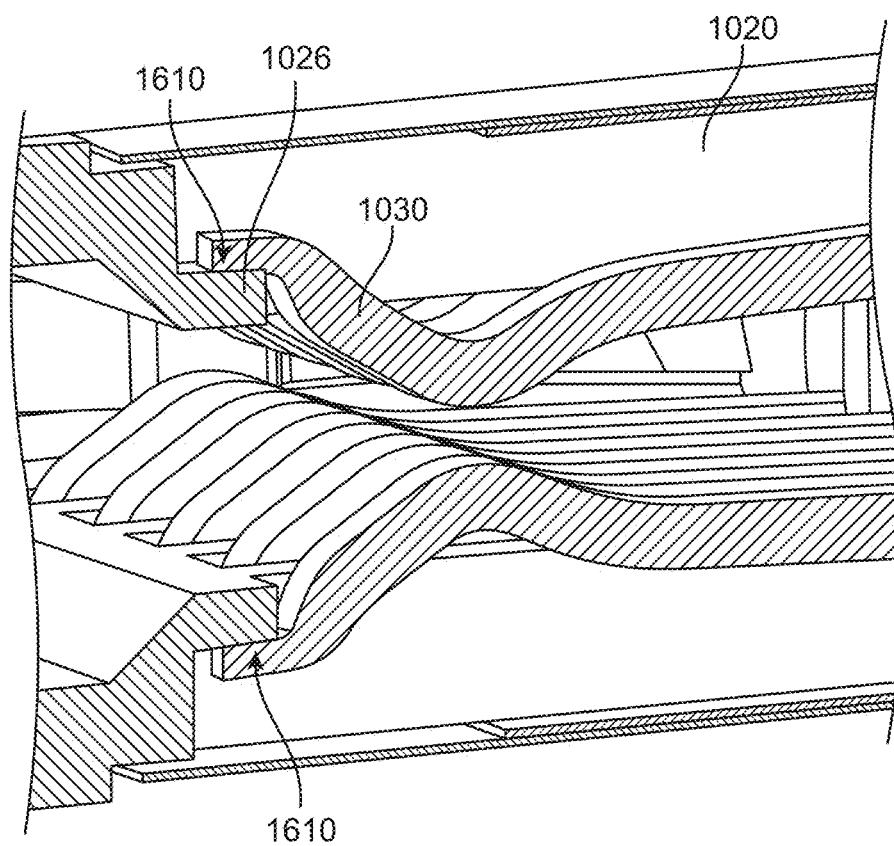


FIG. 16

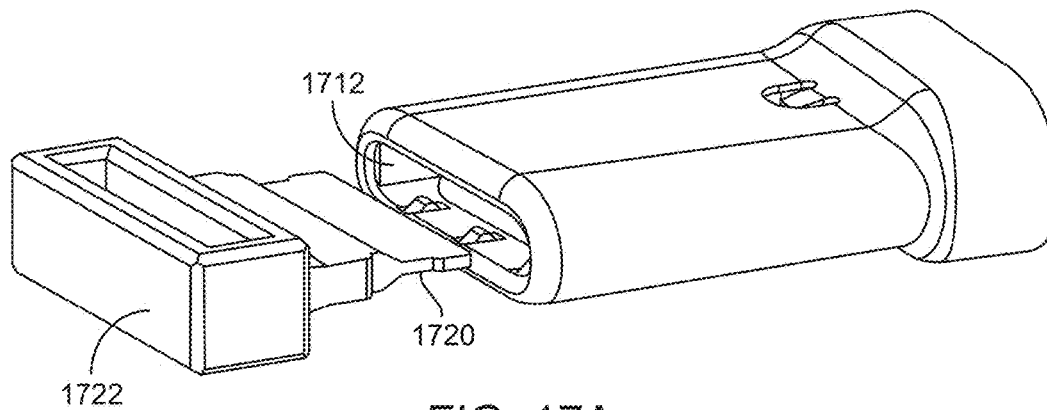


FIG. 17A

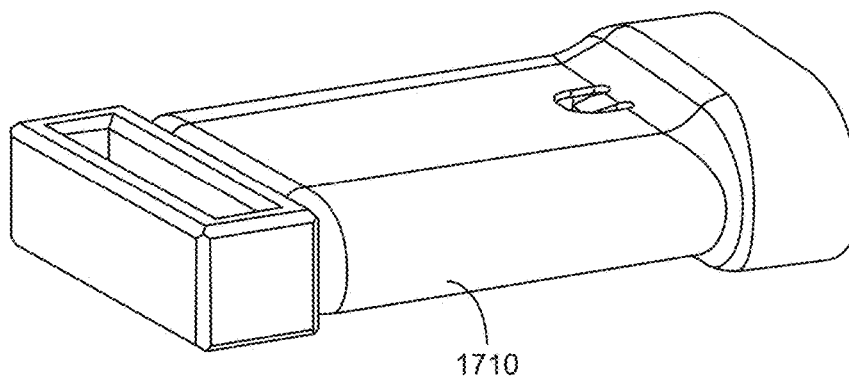


FIG. 17B

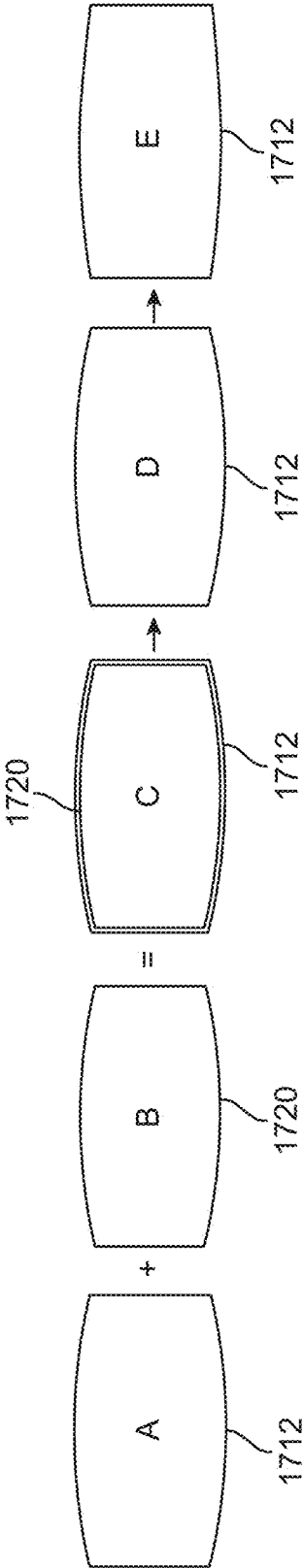


FIG. 18

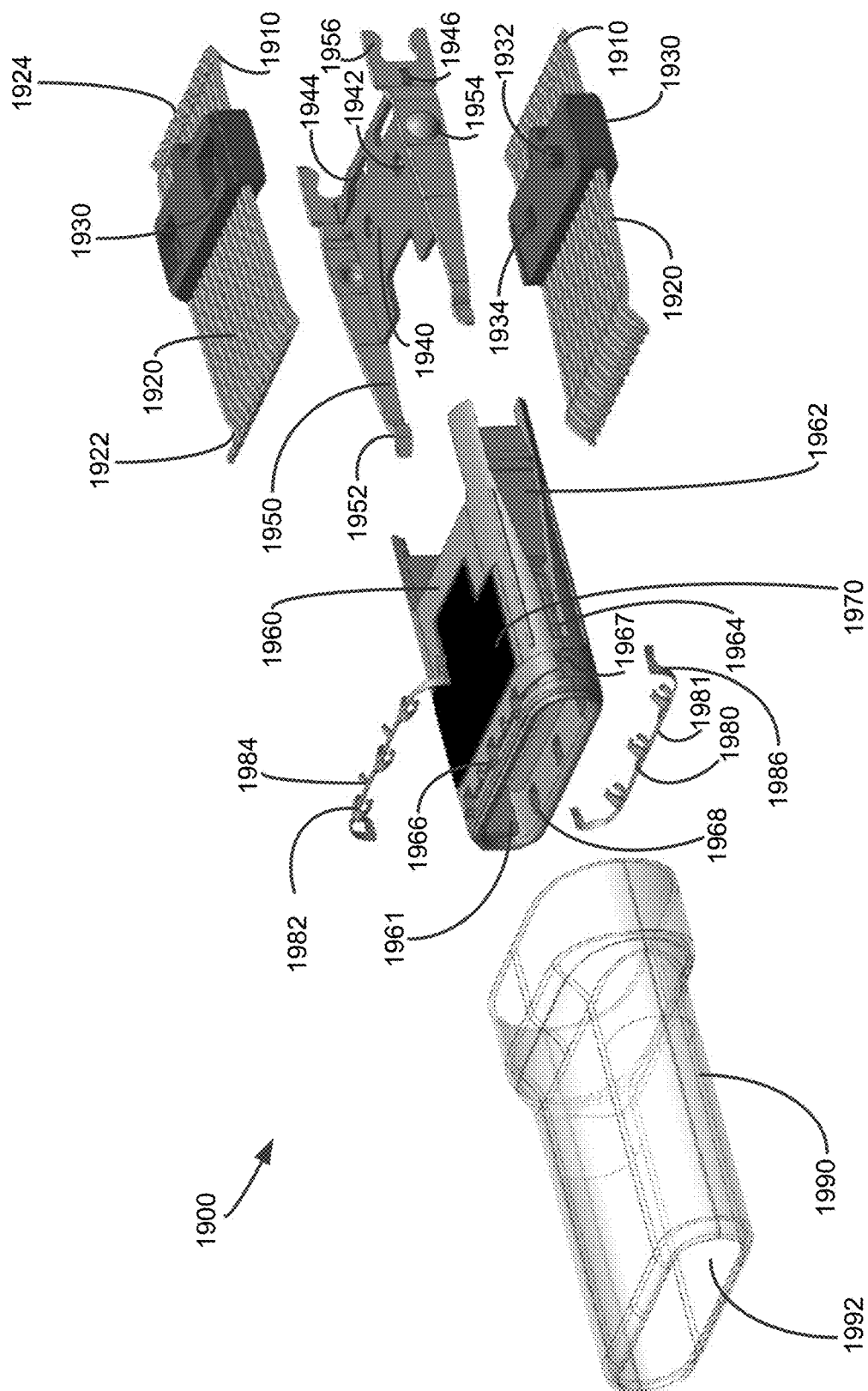


FIG. 19

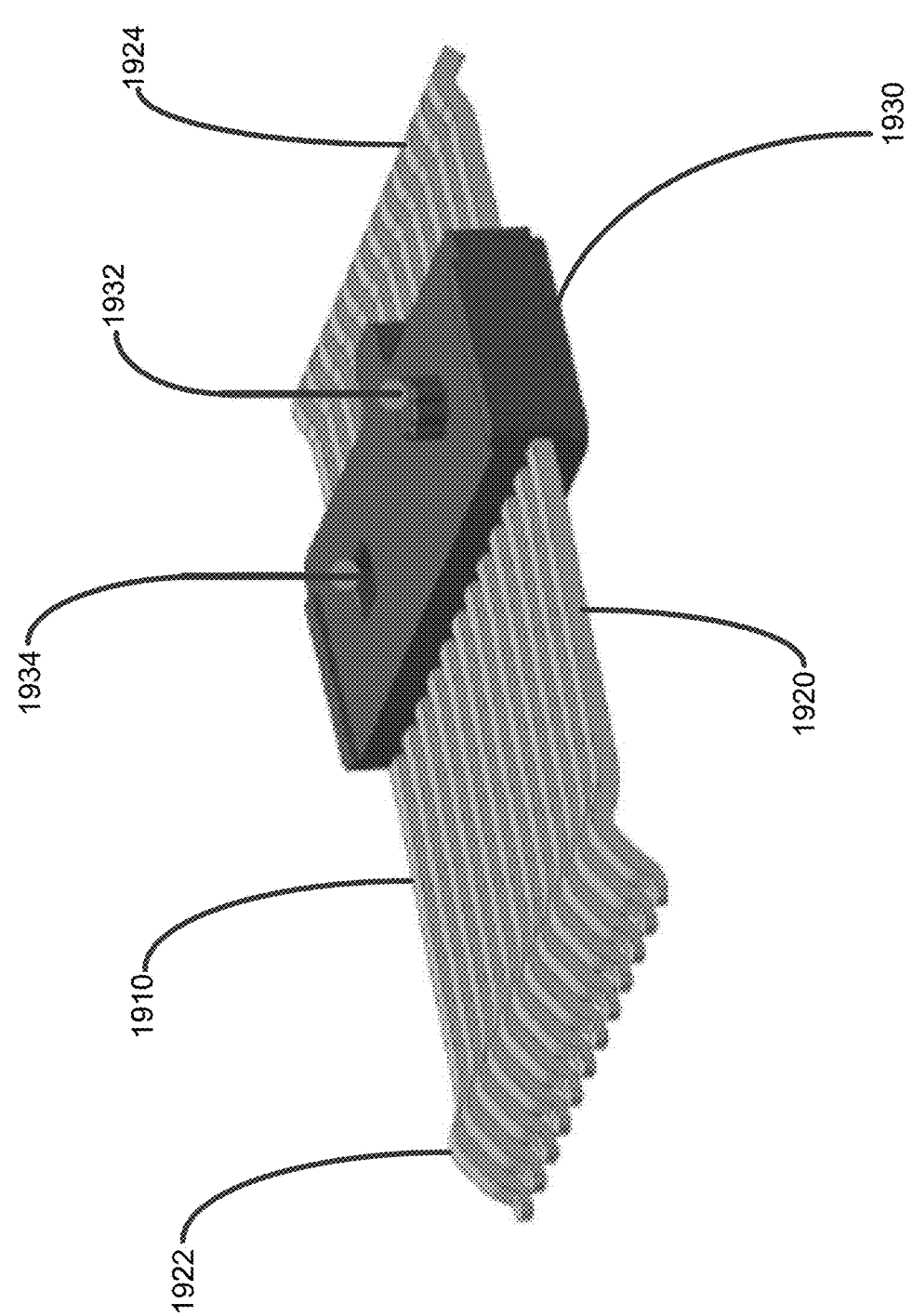


FIG. 20

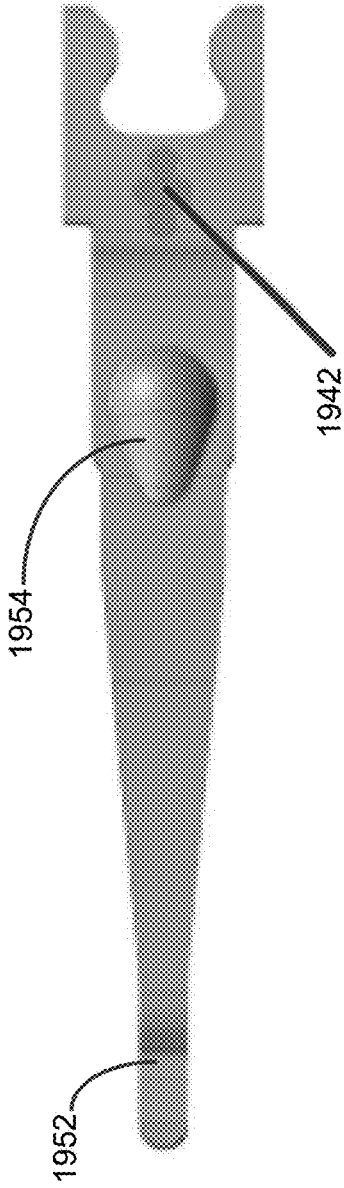
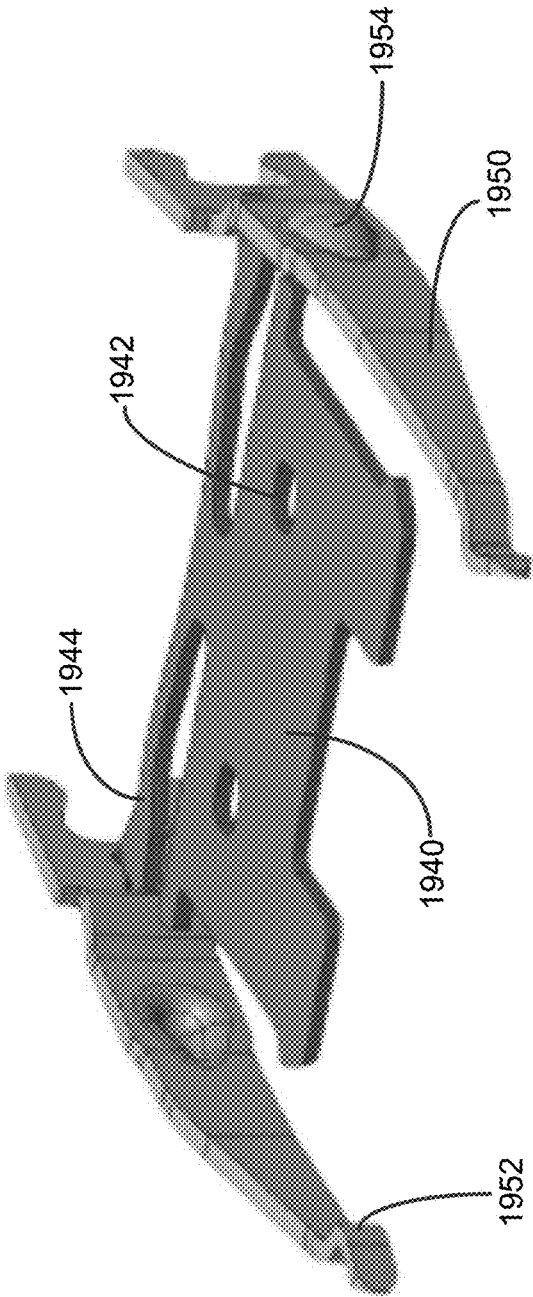


FIG. 21

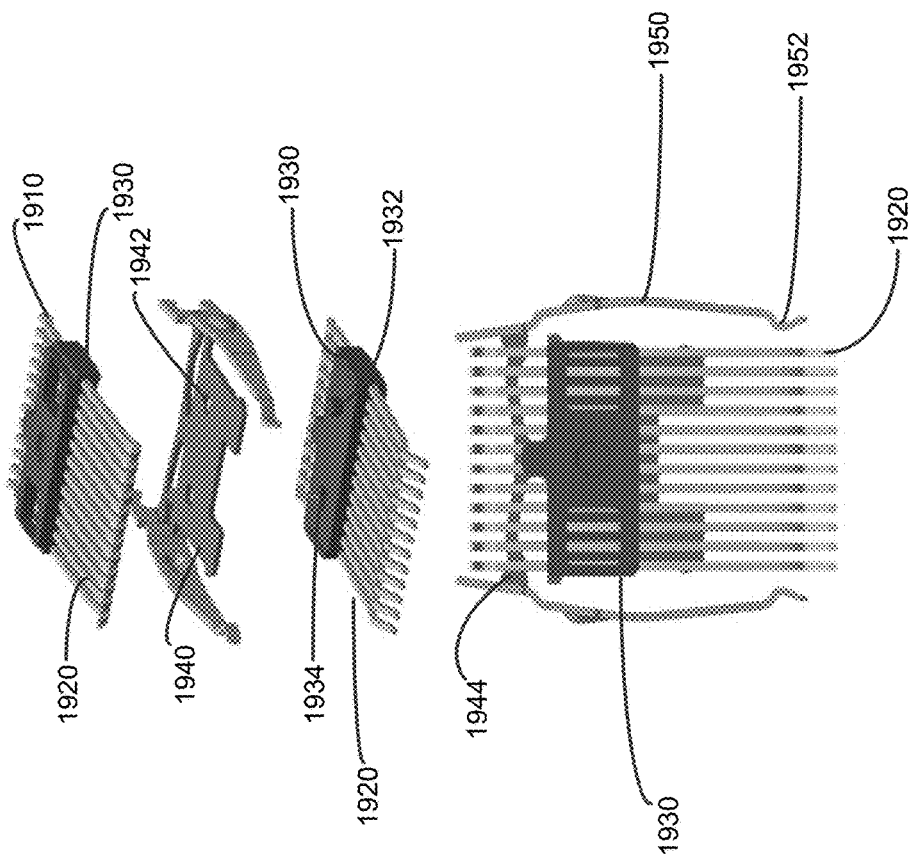


FIG. 22

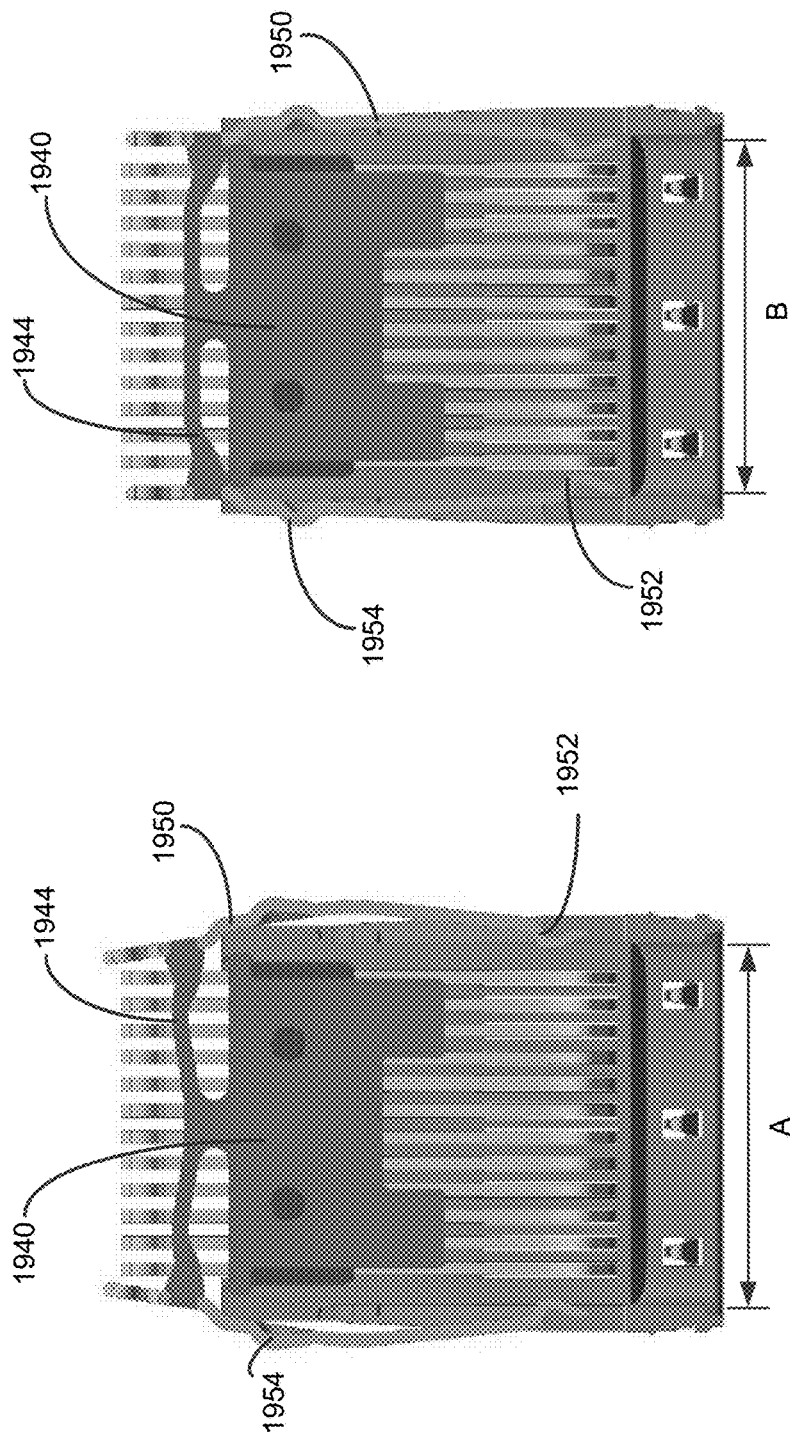


FIG. 23

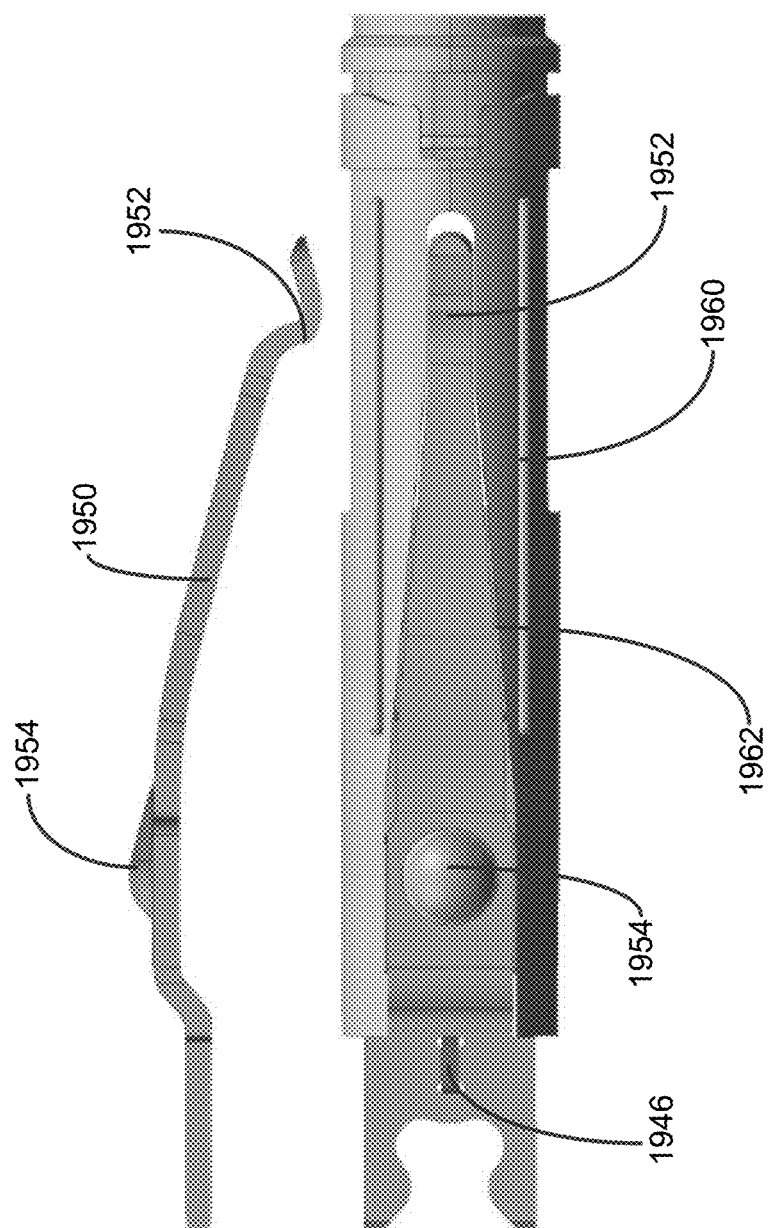


FIG. 24

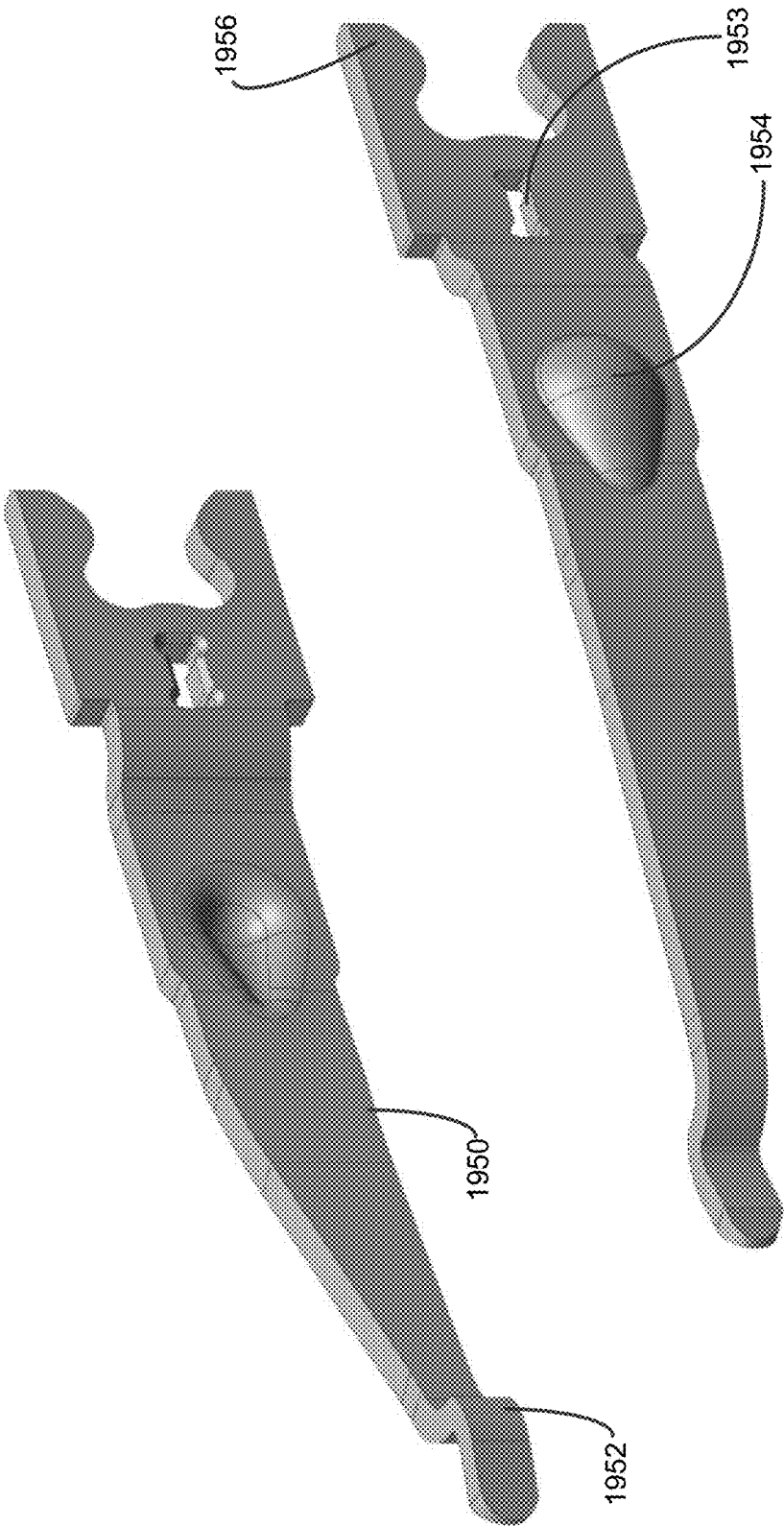


FIG. 25

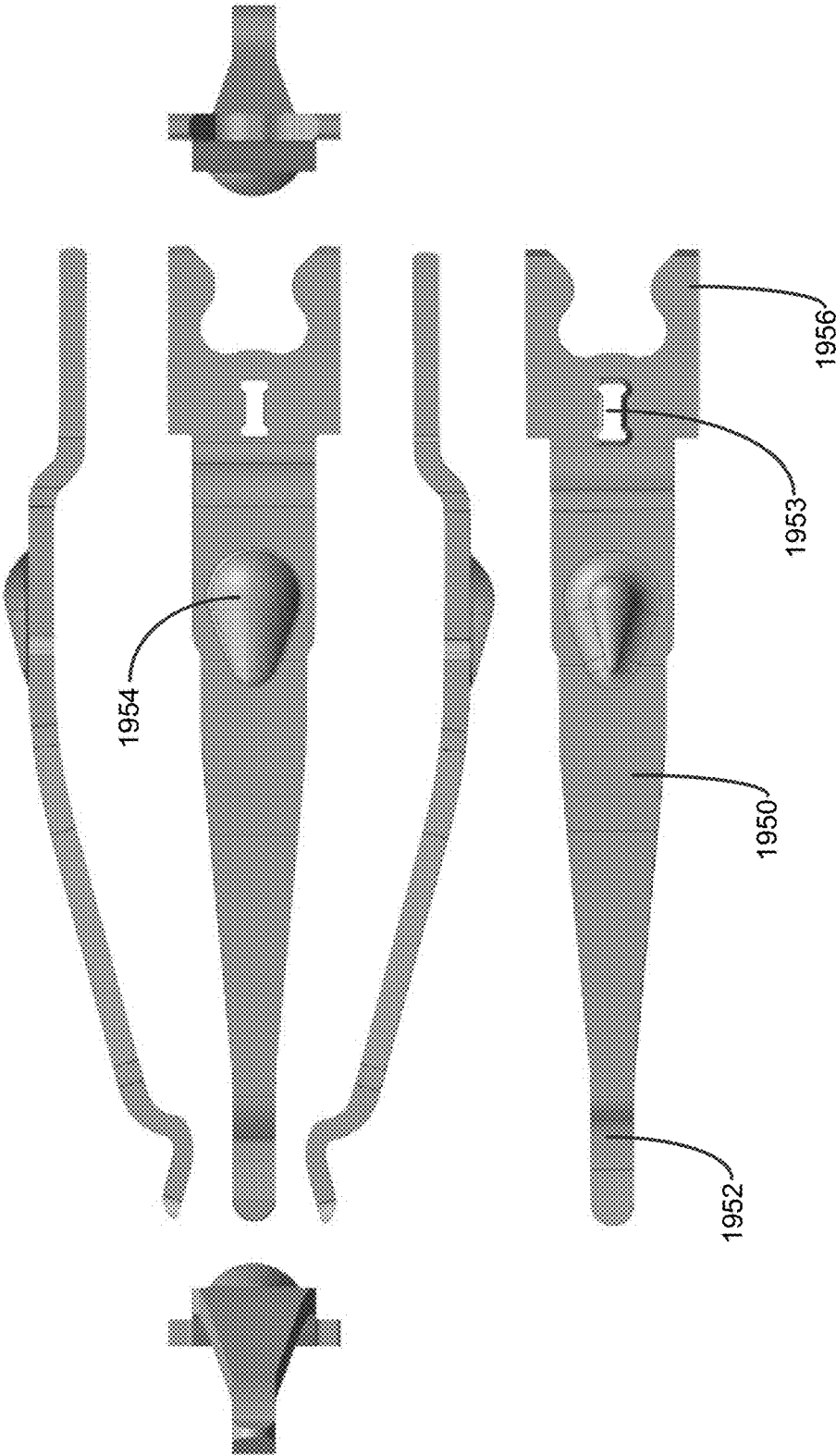


FIG. 26

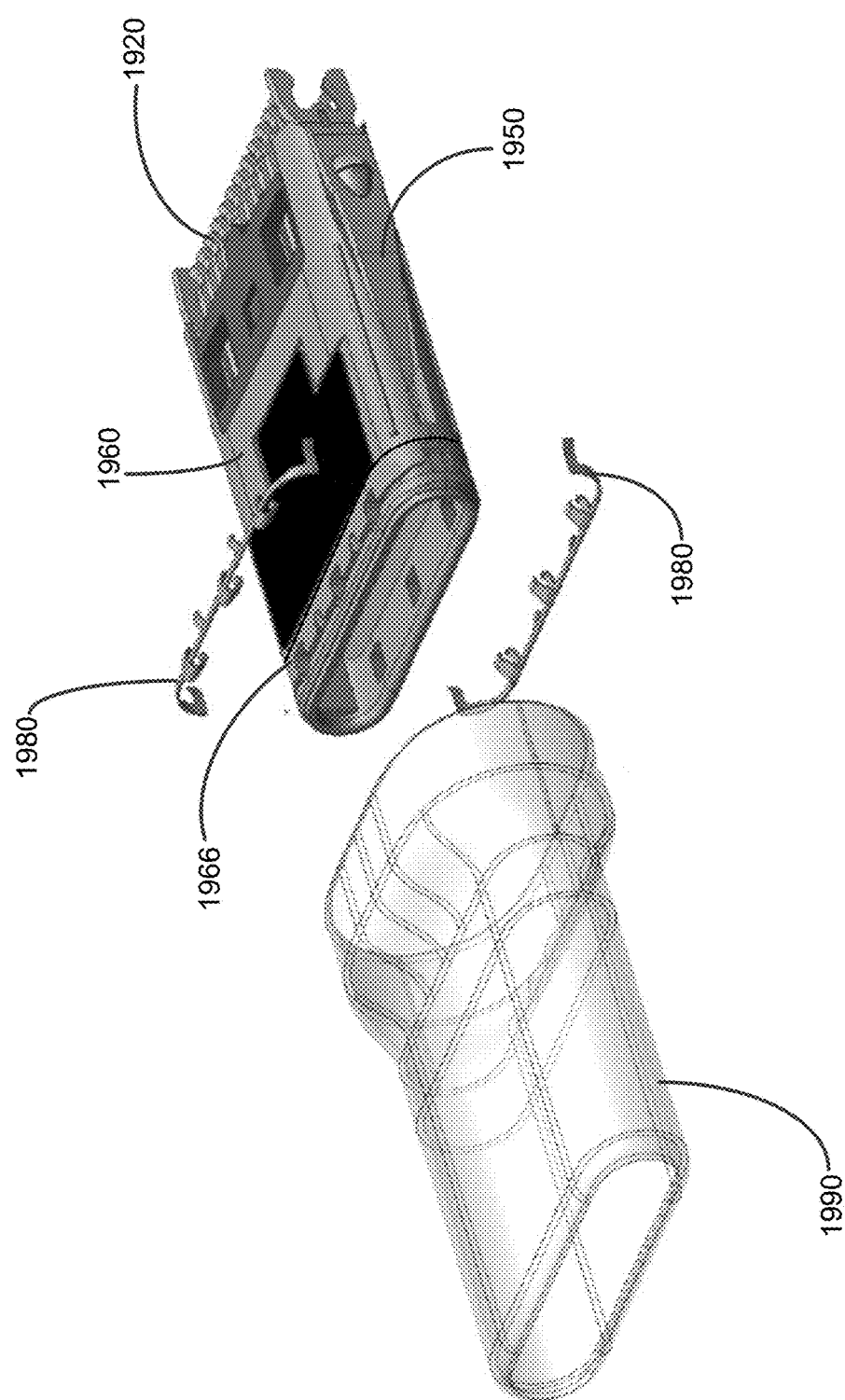


FIG. 27

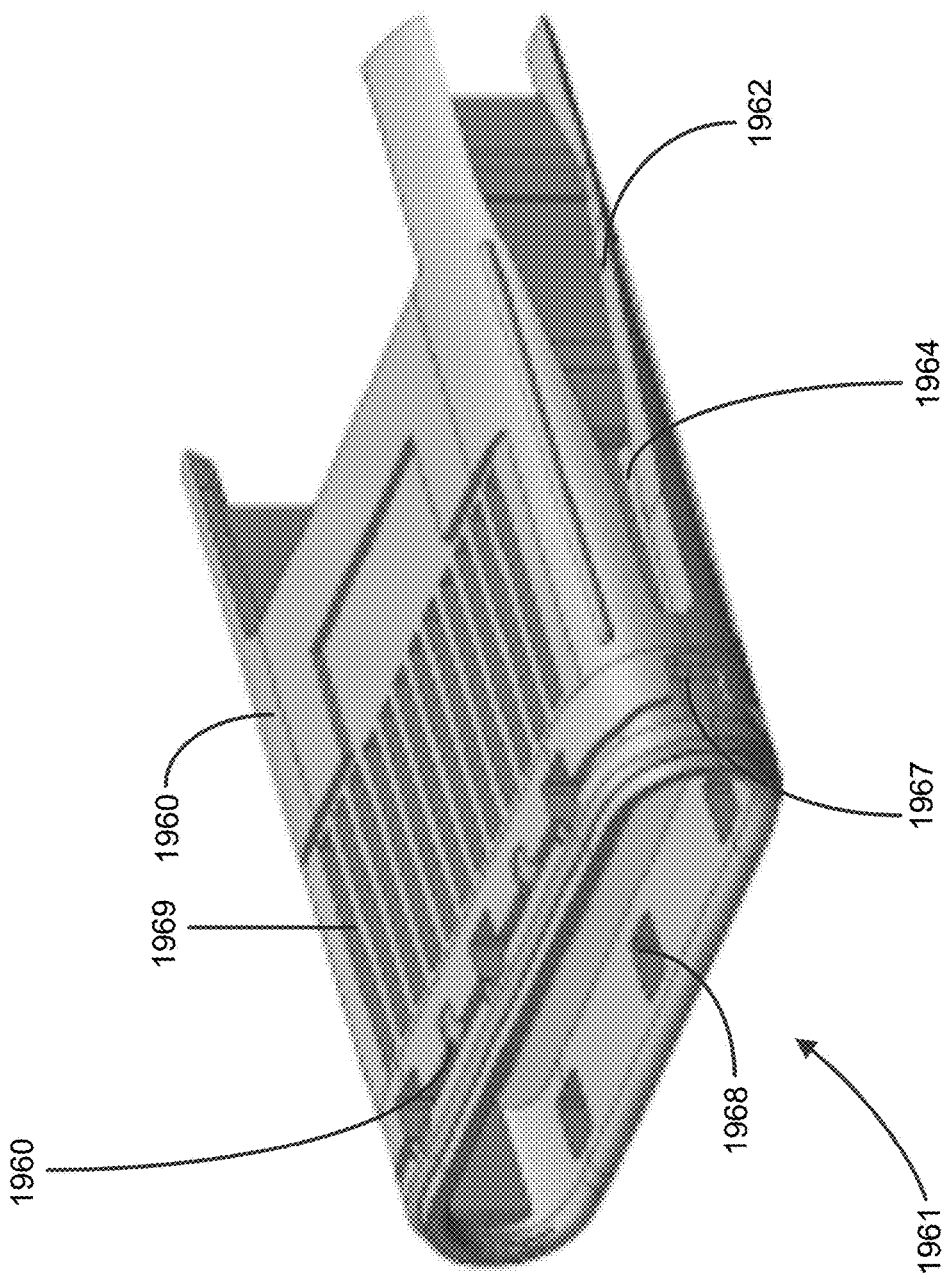


FIG. 28

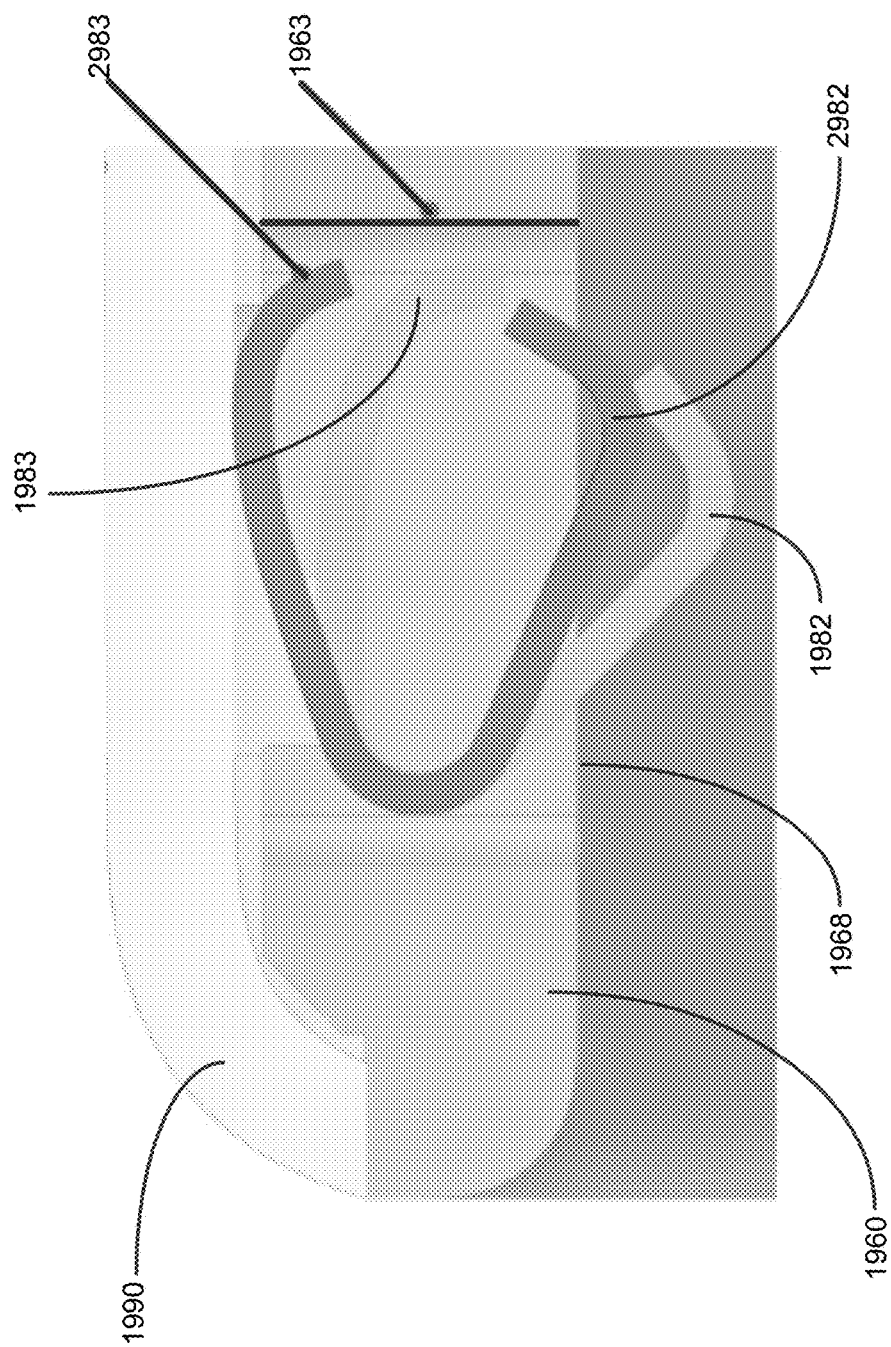


FIG. 29

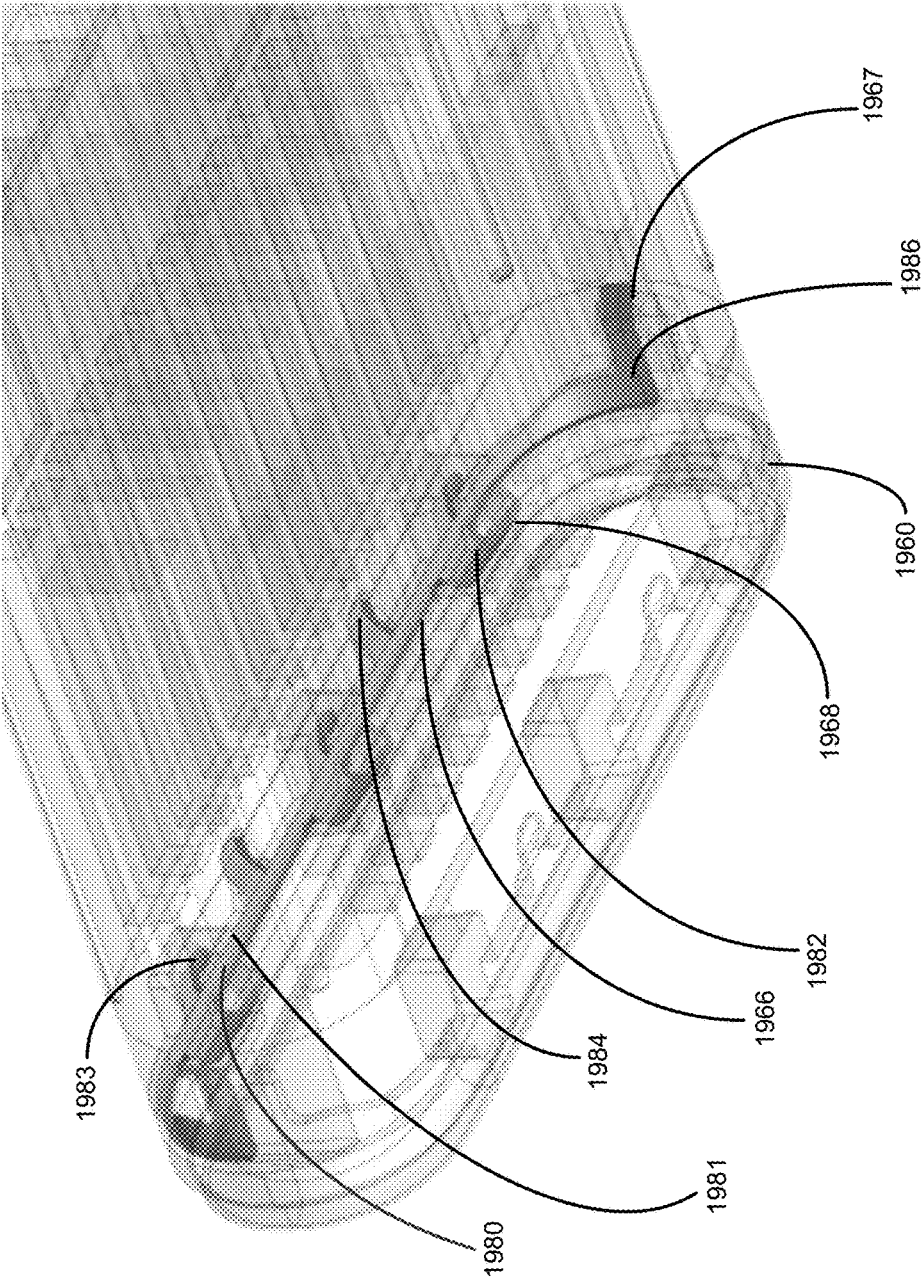


FIG. 30

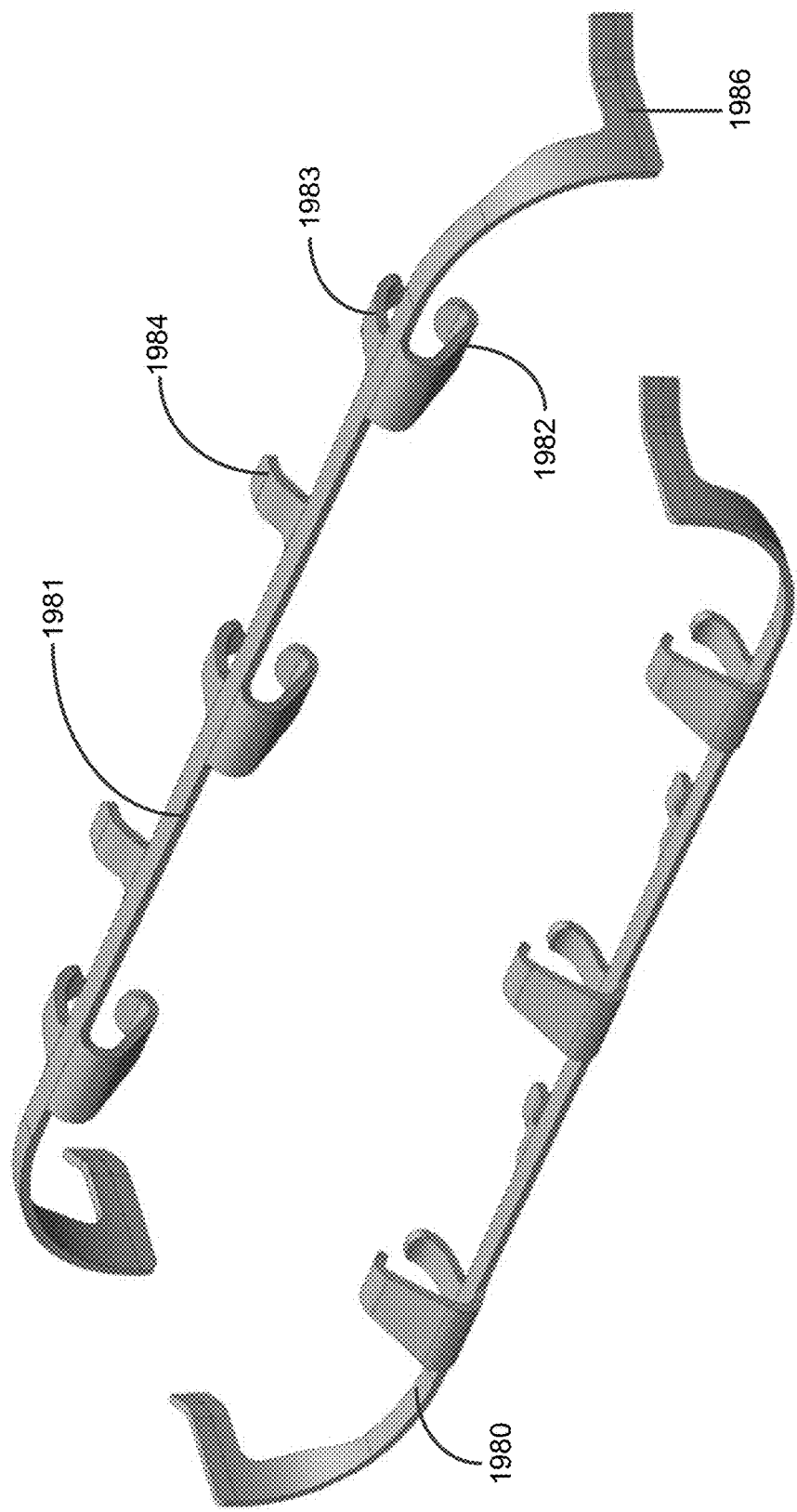


FIG. 31

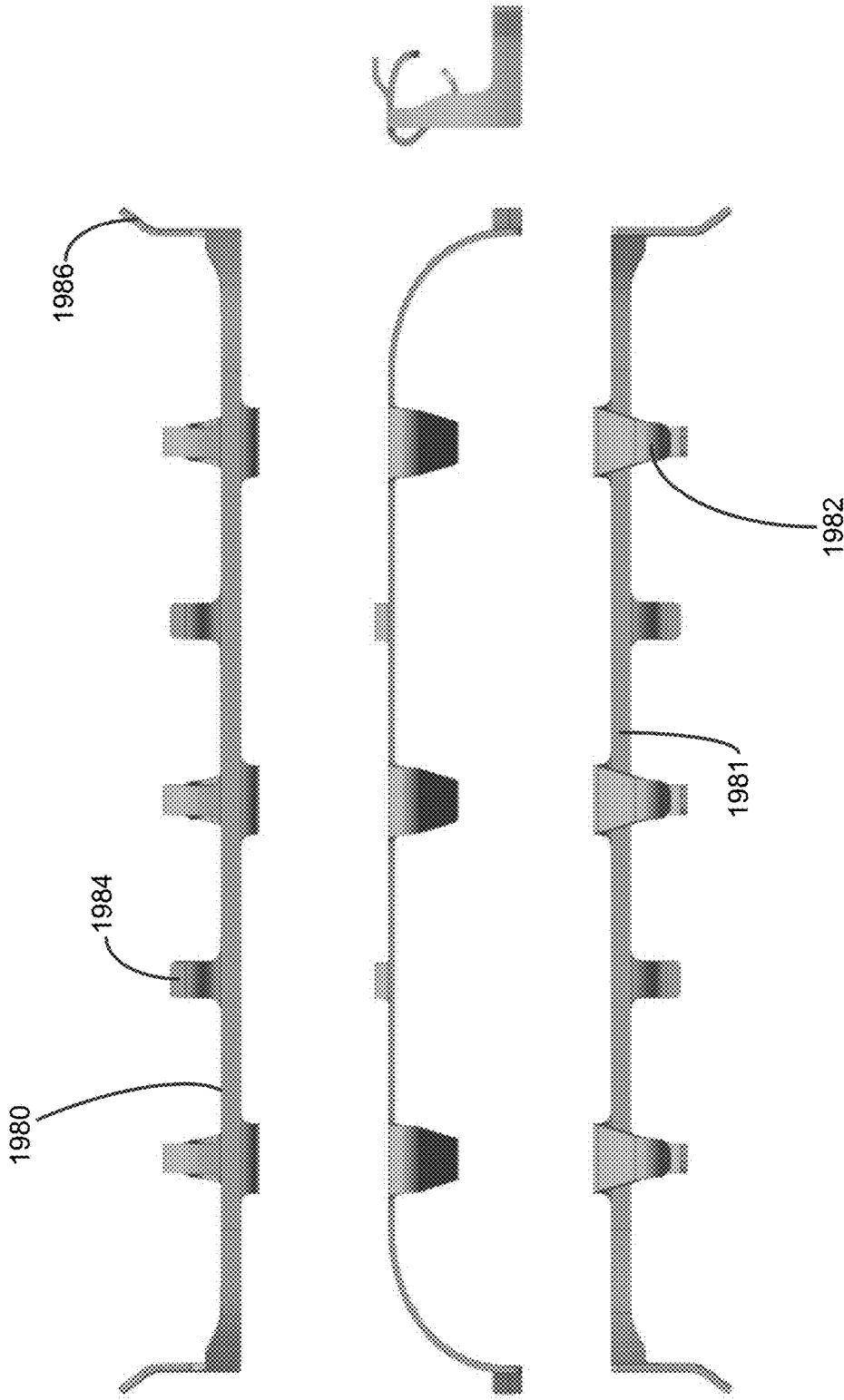


FIG. 32

CONNECTOR INSERT ASSEMBLY

CROSS-REFERENCES TO RELATED APPLICATIONS

[0001] This application is a continuation-in-part of U.S. patent application Ser. No. 15/368,691, filed Dec. 12, 2016, which is a continuation of U.S. patent application Ser. No. 14/641,375, filed Mar. 7, 2015, which is a continuation-in-part of U.S. patent application Ser. No. 14/543,803, filed Nov. 17, 2014, which claims the benefit of U.S. provisional patent application No. 62/003,012, filed May 26, 2014, which are incorporated by reference.

BACKGROUND

[0002] The amount of data transferred between electronic devices has grown tremendously the last several years. Large amounts of audio, streaming video, text, and other types of data content are now regularly transferred among desktop and portable computers, media devices, handheld media devices, displays, storage devices, and other types of electronic devices. Power may be transferred with this data, or power may be transferred separately.

[0003] Power and data may be conveyed over cables that may include wire conductors, fiber optic cables, or some combination of these or other conductors. Cable assemblies may include a connector insert at each end of a cable, though other cable assemblies may be connected or tethered to an electronic device in a dedicated manner. The connector inserts may be inserted into receptacles in the communicating electronic devices to form pathways for power and data.

[0004] The data rates through these connector inserts may be quite high. To provide these high data rates, it may be desirable that these connector inserts have good matching, a high signal integrity, and low insertion loss. This may require the impedance of signal contacts in the connector insert to be matched and close to a target value.

[0005] These connector inserts may be inserted into a device receptacle once or more each day for multiple years. It may be desirable that these connector inserts have and maintain a pleasant physical appearance as a poor appearance may lead to user dissatisfaction with both the cable assembly and the electronic devices that it connects to.

[0006] Electronic devices may be sold in the millions, with an attendant number of cable assemblies and their connector inserts sold alongside. With such volumes, any difficulties in the manufacturing process may become significant. For such reasons, it may be desirable that these connector inserts may be reliably manufactured.

[0007] Thus, what is needed are connector inserts having signal contacts with a matched impedance near a target value for good signal integrity and low insertion loss, a pleasant physical appearance, and that may be reliably manufactured.

SUMMARY

[0008] Accordingly, embodiments of the present invention may provide connector inserts having contacts with a matched impedance near a target value for good signal integrity and low insertion loss, a pleasant physical appearance, and that may be reliably manufactured.

[0009] An illustrative embodiment of the present invention may provide connector inserts having signal contacts with a matched impedance near a target value to improve signal integrity and provide a low insertion loss in order to

allow high data rates. This matching may be achieved in part by increasing an impedance of the signal contacts. For example, various embodiments of the present invention may include ground planes between rows of contacts in a connector in order to electrically isolate signals in the different rows from each other. Also, a grounded shield may surround these rows of contacts. The ground plane and shield may increase capacitance to the signal contacts, thereby lowering the impedance at the contacts below a target value and thereby degrading signal integrity. Accordingly, in order to improve signal integrity and facilitate matching, embodiments of the present invention may thin or reduce thicknesses of one or more of the shield, ground plane, or contacts in order to increase the distances between the structures. This increase in distance may increase the impedance at the contacts to near a target value, again improving matching among the signal contacts.

[0010] In other embodiments of the present invention, the shape of a signal contact when it is in a deflected or inserted state may be optimized. For example, a contact may be contoured to be at a maximum distance from the ground plane and shield over its length in order to increase impedance at the contact. In a specific embodiment of the present invention where the ground plane and shield are substantially flat, the signal contacts may be substantially flat as well, and where either or both the ground plane and shield are curved, the signal contacts may be substantially curved as well.

[0011] In this embodiment of the present invention, the signal contacts of a connector insert may be designed to be substantially flat when the connector insert is inserted into a connector receptacle. This design may also include a desired normal force to be applied to a contact on a connector receptacle by a connector insert signal contact. From this design, the shape of the connector insert signal contacts when the connector insert is not inserted in a connector receptacle may be determined. That is, from knowing the shape of a connector insert signal contact in a deflected state and the desired normal force to be made during a connection, the shape of a connector insert signal contact in a non-deflected state may be determined. The connector insert signal contacts may be manufactured using the determined non-deflected state information. This stands in contrast to typical design procedures that design a contact beginning with the non-deflected state.

[0012] These and other embodiments of the present invention may provide connector inserts having a pleasant appearance. In these embodiments, a leading edge of the connector insert may be a plastic tip. This plastic tip may be a front portion of a housing in the connector insert. Embodiments of the present invention may provide features to prevent light gaps from occurring between the plastic tip and shield. One illustrative embodiment of the present invention may provide a step or ledge on the plastic tip to block light from passing between the plastic tip and the shield. In other embodiments of the present invention, a force may be exerted on the shield acting to keep the shield adjacent to, or in proximity of, the plastic tip. This force may be applied at a rear of the shield by one or more arms having ramped surfaces, where the arms are biased in an outward direction and the ramps are arranged to apply a force to the shield.

[0013] After a connector insert portion has been manufactured, a cable may be attached to it. The cable may include a ground shield or braiding. During cable attachment, the

braiding may be pulled back and a ground cap may be placed over the braiding. The cap may then be crimped to secure the cable in place. The crimping may be done with a multi-section die, where contacting surfaces of the die include various points or peaks along their surface. These points may effectively wrinkle or jog the perimeter of the cap, thereby reducing the dimensions of a cross-section of the cable. This reduction in cross section may improve the flow of plastic while a strain relief is formed around the cable. This may, in turn, increase the manufacturability of the connector insert.

[0014] Another illustrative embodiment of the present invention may include retention springs for a connector insert. These retention springs may engage notches on sides of the tongue of a connector receptacle when the connector insert is inserted into the connector receptacle. These retention springs may include a contacting portion for engaging the notches on the tongue. The retention springs may also include an optional dimple. The dimple, if present, may engage in inside of a shield of the connector insert while the connector insert is inserted into the connector receptacle, otherwise, the retention spring surface itself may engage the inside of the shield while the connector insert is being inserted. In other embodiments of the present invention, the dimple if present, may engage in inside of the shield before the connector insert is inserted, otherwise the retention spring surface itself may engage the inside of the shield before the connector insert is inserted. The retention spring may include a deflection arm extending from the dimple, if present, to the contacting portion. In other embodiments of the present invention, the deflection arm may extend from a location where the retention spring contacts the shield to the contacting portion. A majority of the length of the retention spring may be made up of this deflection arm. This deflection arm may deflect as the connector insert is inserted into a connector receptacle. In this way, stresses may be spread out over the retention spring during insertion. This may help to avoid a concentration of stress that could otherwise cause a cold working failure or cracking in the retention spring. Specifically, a surface or dimple (if present) may contact a surface, such as a shield, when the connector insert starts to be inserted into a connector receptacle. Force or stress may concentrate here, but the retention spring may be made thicker or wider in one or more directions here to support the stress. As the insert continues to be inserted, the deflection arm may deflect, absorbing stresses over a long portion of the retention spring. Particularly where no dimple is present, the contact area between the retention spring and shield or other surface may “rock” or move along the length of the retention spring (towards the contacting portion), again helping to distribute the points of high stress compensation. This configuration may provide a retention spring that is hard enough to provide a good retention force but not fail due to cold working. These retention springs may be formed in various ways. For example, they may be forged, stamped, metal-injection-molded, or formed in other ways.

[0015] Another illustrative embodiment of the present invention may include ground contacts near a front opening of the connector insert. These ground contacts may be connected by a cross piece. The cross piece may be supported by one or more spring structures, which may wrap laterally around a front portion of a housing for the connector insert. In a specific embodiment of the present invention,

the support structures may wrap around approximately one-half of a circumference of the housing.

[0016] Another illustrative embodiment of the present invention may provide a connector insert having a front lip. An inside portion of the front lip may be formed of a nonconductive housing, while an outside portion may be formed of a conductive shield. This arrangement may help to prevent the conductive shield from contacting and shorting contacts on a tongue of a connector receptacle while the connector insert is inserted into the connector receptacle. To further protect against shorting receptacle contacts, the housing may be arranged to be either aligned with or extending beyond the shield. Also, having a portion of lip formed by the shield may help to strengthen a leading edge of the connector insert.

[0017] The signal contacts included in a connector insert according to an embodiment of the present invention may be pre-biased to provide a force against contacts on a top of a connector receptacle. This pre-bias may provide a force at a front opening of the connector insert in a direction such that the opening may tend to close up. Accordingly, embodiments of the present invention may provide an end cap having bowed outside edges. These outwardly bowed edges may provide a countervailing force during manufacturing to help the opening of the connector insert to remain open.

[0018] These and other embodiments of the present invention may provide retention springs for connector inserts, where the retention springs are preloaded. Specifically, the retention springs may be attached to articulating arms extending from a central ground plane. After attachment to the central ground plane, the retention springs may have a greater spacing between contacting portions than necessary. As the retention springs are inserted into a shield of the connector insert, a compressive force may be applied to sides of the retention springs such that the articulating arms are angled towards the central ground plane and the contacting portions are driven closer together. This compression may also provide a preloading on the retention springs. When a connector receptacle tongue is inserted into the connector insert, a user may have to overcome the preloading of the retention spring before the tongue may continue to be inserted. This preloading may provide the connector insert with a more consistent insertion profile, more stable normal forces, and a greater durability. It may simplify manufacturing of the retention springs, allowing the use of softer materials that may be stamped instead of being forged. These retention springs may have a more uniform thickness along their length, since the insertion profile of the connector is not being primarily determined by the shape of the retention springs. The retention springs may be laser welded to the articulating arms extending from the central ground plane at several locations. This may provide an attachment between the retention springs and the central ground plane that may withstand the application of force during assembly as well as the preloading force. The attached retention springs and the central ground plane may form a unit that is easily mated to a connector insert housing to simplify assembly.

[0019] These and other embodiments of the present invention may provide ground contacts near a front opening of the connector insert. These ground contacts may be included on electromagnetic interference (EMI) springs. (The term EMI springs may also refer more generally to ground contacts, as in the examples above.) These EMI springs may include

continuous crossbars. These consecutive crossbars may be formed separately and joined or they may be formed as a single piece. Ground contacts may be located at junctions of the crossbars. Attaching the ground contacts to the crossbars themselves may reduce an amount of housing that may need to be removed to make space for the EMI springs. That is, with a reduced thickness to the EMI springs, a channel or guide holding the EMI springs may be shallower narrower, thereby allowing the housing to be thicker and more rigid. The more substantial housing may minimize warpage of the housing near the front of the connector insert. The ground contacts may be exposed at openings in a housing for the connector insert. The crossbars may be located in a channel or guide in the housing, where the channel or guide extends laterally across and near the front of the connector insert housing. These EMI springs may extend nearly 180 degrees around the opening of the connector insert. The outside crossbars may include feet that snap or otherwise fit in a right-angle portion of the channel or guide, where the right-angle portion extends in a direction orthogonal to the remainder of the channel or guide and away from the front of the connector insert. The ground contacts may extend from the crossbars into a central passage of the connector insert and may be folded back into the passage. The ground contacts may also include lateral extensions that extend roughly parallel to the central passage. During insertion of a tongue into the connector insert, these lateral extensions may prevent the ground contacts from being pushed back into the connector insert between the shield and the housing. Shield contacts may be located between the ground contacts, and may extend from the two center crossbars away from the central passage of the connector insert where they may contact the outside shield of the connector insert. These shield contacts may also push against the shield thereby helping to hold the EMI springs in place. The crossbars may have a torsion force applied during their assembly into the housing. This, along with the flexibility of the crossbars and the ground contacts themselves, may help to more evenly distribute forces when the ground contacts engage a connector receptacle tongue. By more evenly distributing forces, the amount of permanent deformation of the EMI springs may be reduced. Also, the force applied to a connector receptacle tongue by the ground contacts may be reduced, thereby reducing wear on the tongue. This force may further be refined by tapering one or more of the crossbars in one or more directions along their length.

[0020] In various embodiments of the present invention, contacts, shields, and other conductive portions of connector inserts and receptacles may be formed by stamping, metal-injection molding, machining, micro-machining, 3-D printing, forging, or other manufacturing process. The conductive portions may be formed of stainless steel, steel, copper, copper titanium, phosphor bronze, or other material or combination of materials. They may be plated or coated with nickel, gold, or other material. The nonconductive portions may be formed using injection or other molding, 3-D printing, machining, or other manufacturing process. The nonconductive portions may be formed of silicon or silicone, rubber, hard rubber, plastic, nylon, liquid-crystal polymers (LCPs), or other nonconductive material or combination of materials. The printed circuit boards used may be formed of FR-4, BT or other material. Printed circuit boards may be replaced by other substrates, such as flexible circuit boards, in many embodiments of the present invention.

[0021] Embodiments of the present invention may provide connector inserts and receptacles that may be located in, and may connect to, various types of devices, such as portable computing devices, tablet computers, desktop computers, laptops, all-in-one computers, wearable computing devices, cell phones, smart phones, media phones, storage devices, portable media players, navigation systems, monitors, power supplies, adapters, remote control devices, chargers, and other devices. These connector inserts and receptacles may provide pathways for signals that are compliant with various standards such as one of the Universal Serial Bus (USB) standards including USB-C, High-Definition Multimedia Interface® (HDMI), Digital Visual Interface (DVI), Ethernet, DisplayPort, Thunderbolt™, Lightning™, Joint Test Action Group (JTAG), test-access-port (TAP), Directed Automated Random Testing (DART), universal asynchronous receiver/transmitters (UARTs), clock signals, power signals, and other types of standard, non-standard, and proprietary interfaces and combinations thereof that have been developed, are being developed, or will be developed in the future. Other embodiments of the present invention may provide connector inserts and receptacles that may be used to provide a reduced set of functions for one or more of these standards. In various embodiments of the present invention, these interconnect paths provided by these connector inserts and receptacles may be used to convey power, ground, signals, test points, and other voltage, current, data, or other information.

[0022] Various embodiments of the present invention may incorporate one or more of these and the other features described herein. A better understanding of the nature and advantages of the present invention may be gained by reference to the following detailed description and the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

[0023] FIG. 1 illustrates a connector insert according to an embodiment of the present invention that has been inserted into a connector receptacle according to an embodiment of the present invention;

[0024] FIG. 2 illustrates a portion of a connector system according to an embodiment of the present invention;

[0025] FIG. 3 illustrates signal contacts in a deflected or inserted state according to an embodiment of the present invention;

[0026] FIG. 4 illustrates signal contact in a non-deflected or extracted state according to an embodiment of the present invention;

[0027] FIG. 5 illustrates a front end of a connector insert according to an embodiment of the present invention;

[0028] FIG. 6 illustrates a portion of a connector insert according to an embodiment of the present invention;

[0029] FIG. 7 illustrates a portion of a connector insert according to an embodiment of the present invention;

[0030] FIG. 8 illustrates a cutaway view of a portion of a connector insert according to an embodiment of the present invention;

[0031] FIG. 9 illustrates a structure for crimping a cap around an end of a cable according to an embodiment of the present invention;

[0032] FIG. 10 illustrates an exploded view of a connector insert according to an embodiment of the present invention;

[0033] FIG. 11 illustrates a retention spring that may be used in a connector insert according to an embodiment of the present invention;

[0034] FIG. 12 illustrates a top cut-away view of a connector insert according to an embodiment of the present invention;

[0035] FIG. 13 illustrates a front view of a connector insert according to an embodiment of the present invention;

[0036] FIG. 14 illustrates a connector insert portion and a ground contact according to an embodiment of the present invention;

[0037] FIG. 15 illustrates steps in the manufacturing of a connector insert according to an embodiment of the present invention;

[0038] FIG. 16 illustrates forces being exerted at a connector insert opening according to an embodiment of the present invention;

[0039] FIGS. 17A-17B illustrate an end cap being inserted into an opening of a connector insert according to an embodiment of the present invention;

[0040] FIG. 18 illustrates the operation of an end cap that may be employed during manufacturing of a connector insert according to an embodiment of the present invention;

[0041] FIG. 19 illustrates another connector insert according to an embodiment of the present invention;

[0042] FIG. 20 illustrates a contact assembly for a connector insert according to an embodiment of the present invention;

[0043] FIG. 21 illustrates a central ground plane and retention springs for a connector insert according to an embodiment of the present invention;

[0044] FIG. 22 illustrates a portion of the assembly of a connector insert according to an embodiment of the present invention;

[0045] FIG. 23 illustrates a preloading of retention springs according to an embodiment of the present invention;

[0046] FIG. 24 illustrates views of retention springs according to an embodiment of the present invention;

[0047] FIGS. 25-26 illustrate further views of retention springs according to an embodiment of the present invention;

[0048] FIG. 27 illustrates a portion of an assembly of a connector insert according to an embodiment of the present invention;

[0049] FIG. 28 illustrates a housing for a connector insert according to an embodiment of the present invention;

[0050] FIG. 29 illustrates a side view of a portion of a connector insert according to an embodiment of the present invention;

[0051] FIG. 30 illustrates a portion of a connector insert according to an embodiment of the present invention; and

[0052] FIGS. 31-32 illustrate EMI springs according to an embodiment of the present invention.

DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

[0053] FIG. 1 illustrates a connector insert according to embodiments of the present invention that is been inserted into a connector receptacle according to an embodiment of the present invention. This figure, as with the other included figures, is shown for illustrative purposes and does not limit either the possible embodiments of the present invention or the claims.

[0054] Specifically, connector insert 110 has been inserted into connector receptacle 120. Connector receptacle 120 may be located in various types of devices, such as portable computing devices, tablet computers, desktop computers, laptops, all-in-one computers, wearable computing devices, cell phones, smart phones, media phones, storage devices, portable media players, navigation systems, monitors, power supplies, adapters, remote control devices, chargers, and other devices. Connector insert 110 and connector receptacle 120 may provide pathways for signals that are compliant with various standards such as one of the Universal Serial Bus (USB) standards including USB-C, High-Definition Multimedia Interface® (HDMI), Digital Visual Interface (DVI), Ethernet, DisplayPort, Thunderbolt™, Lightning™, Joint Test Action Group (JTAG), test-access-port (TAP), Directed Automated Random Testing (DART), universal asynchronous receiver/transmitters (UART5), clock signals, power signals, and other types of standard, non-standard, and proprietary interfaces and combinations thereof that have been developed, are being developed, or will be developed in the future. In other embodiments of the present invention, connector insert 110 and connector receptacle 120 may be used to provide a reduced set of functions for one or more of these standards. In various embodiments of the present invention, these interconnect paths provided by connector insert 110 and connector receptacle 120 may be used to convey power, ground, signals, test points, and other voltage, current, data, or other information. More information about connector insert 110 and connector receptacle 120 may be found in co-pending United States patent application number, filed, attorney docket number 90911-P21847US1, titled CONNECTOR RECEPTACLE HAVING A SHIELD, which is incorporated by reference.

[0055] Connector insert 110 may include a number of contacts for conveying signals. These signals may include high-speed differential signals, as well as other types of signals. To increase signal integrity and reduce insertion losses, it may be desirable to increase an impedance of the signal contacts. More specifically, it may be desirable to match the impedance across the various contacts in a connector plug or insert so that they all have a value near a target value. In some embodiments of the present invention, this matching is facilitated by decreasing capacitances between the signal contacts in the connector insert to other conductive structures in the connector insert 110 and connector receptacle 120. This may be done by increasing the physical spacing between the signal contacts and these other structures.

[0056] Various connector receptacles may include ground structures, such as shields or center or central ground planes, or both. These shields and ground planes may have a particularly contour, which may be but is not necessarily flat. The signal contacts may then be designed to have a similar contour when they are deflected due to the connector insert being inserted into a connector receptacle. From this deflected shape, a non-deflected shape may be determined. From this non-deflected shape the contact may be formed. Variations between the shape of the contact and the shape of the ground structures may exist. These variations may be adjusted based at least in part on a desired contact force between the contact for the connector insert and a corresponding contact in a connector receptacle. This contact force may also at least partially account for differences

between the deflected and non-deflected shapes of the contact for the connector insert. An example of this is shown in the following figures.

[0057] FIG. 2 illustrates a portion of a connector system according to an embodiment of the present invention. This figure includes a connector insert 110 having signal contacts 112 and 114, shield 118, and center ground plane 119. This figure also includes a connector receptacle 120 including a tongue 122 having a center ground plane 129, shield 128, and contacts 124. Contacts 124 may engage contacts 112 and 114 at locations 113 when connector insert 110 is inserted into connector receptacle 120. Ground contacts, such as ground contacts 230, may electrically connect to contacts 240 on receptacle tongue 122. Ground contacts 240 may connect to shield 128 in the receptacle, which may electrically connect to shield 118 on the insert. Shield 118 may connect to ground contact 230, thereby forming a ground shield around tongue 122 and contacts 114.

[0058] Since contacts 112 and 114 are between shield 118 (and shield 128) and center ground planes 119 and 129, contacts 112 and 114 may capacitively couple to shield 118 and center ground planes 119 and 129. This capacitance may increase with decreasing distance. This increase in capacitance may reduce the impedance at signal contacts 112 and 114, thereby reducing signal integrity. This reduction in capacitance may complicate the overall goal of matching the impedance near a target value at signal contacts 112 and 114.

[0059] Accordingly, embodiments of the present invention may reduce a thickness of one or more of signal contacts 112 and 114, shield 118, shield 128, and center ground planes 119 and 129. These decreasing thicknesses may increase a distance or spacing between these structures, thereby increasing impedance. In other embodiments of the present invention, signal contacts 112 and 114 may be contoured to increase distances, such as distances 202 and 204 to center ground planes 119 and 129, and distances 208 and 209 to shields 118 and their associated ground contacts. For example, where shield 128 and center ground plane 119 may be curved, contacts 112 and 114 may be curved as well in order to maximize these distances. In a special case as illustrated, center ground plane 119, center ground plane 129 in the tongue of connector receptacle 120, and shields 118 and 128 have substantially straight or flat surfaces. Accordingly, signal contact 112 and 114 may be arranged to be substantially flat in a deflected state when in the connector insert is inserted into the connector receptacle.

[0060] Signal contacts 112 and 114 may be designed using a method according to an embodiment of the present invention, where the design process begins with signal contacts 112 and 114 in this nearly flat or straight deflected state. That is, signal contacts may be designed to follow the contours of the center ground planes 119 and 129 and shields 118 and 128 in the state where connector insert 110 is inserted into connector receptacle 120. A desired normal force at location 113 may be factored in as well. From this, a shape of signal contacts 112 and 114 in a non-deflected or extracted state may be determined. Signal contacts 112 and 114 may be manufactured in this state and used an embodiment of the present invention. This stands in contrast to conventional design techniques that begin by designing a signal contact in a non-deflected or non-inserted state.

[0061] Unfortunately, it may be problematic to form signal contacts 112 and 114 such that they are completely flat in a deflected state. For example, at least a slight amount of

curvature at location 113 may be desirable such that contact is made between signal contact 112 in the connector insert and signal contact 124 in the connector receptacle. Specifically, without such curvature, a portion of connector insert signal contact 112 may rest on a front of the tongue 122. This may cause contact 112 to lift at location 113 and disconnect from connector receptacle contact 124. Also, to avoid tongue 122 from engaging an edge of signal contact 112 during insertion, a raised portion 115 having a sloped leading edge and a tip 116 may be included at an end of signal contact 112. This raised portion 115 may cause a localized drop or dip in the impedance of signal contact 112. To reduce this dip or reduction in impedance, raised portion 115 may have a substantially flat surface at tip 116 in an attempt to increase the distance between tip 116 and shield 118. That is, tip 116 may have a top surface that is substantially parallel to shield 118.

[0062] FIG. 3 illustrates signal contacts in a deflected or inserted state according to an embodiment of the present invention. As shown, contacts 112 may be substantially flat. Deviations from this at location 113 may be present, as described above. From this arrangement, as well as the desired force to be applied at location 113, the shape of signal contacts 112 in a non-deflected state may be determined. An example is shown in the following figure.

[0063] FIG. 4 illustrates signal contact in a non-deflected or extracted state according to an embodiment of the present invention. As shown, contacts 112 and 114 may bend towards each other in the non-inserted state. Signal contacts 112 and 114 may be manufactured in the non-deflected state and used an embodiment of the present invention. Again, when the connector insert including contact 112 is inserted in a corresponding connector receptacle, contact 112 may defect to a substantially flat or straight position.

[0064] Various embodiments of the present invention may include a tip, formed of plastic or other material, on a front leading edge of a connector insert. In these embodiments of the present invention, it may be desirable to ensure that there are no gaps or spaces visible between the plastic tip and shield of a connector insert. Accordingly, embodiments of the present invention may provide features to reduce or limit these gaps. Examples are shown in the following figures.

[0065] FIG. 5 illustrates a front end of a connector insert according to an embodiment of the present invention. In this example, plastic tip 520 may be located on a front of the connector insert next to shield 510. That is, shield 510 may meet the plastic tip 520 at a rear of the plastic tip 520 away from a front of the connector insert. While plastic tip 520 may be made of plastic, it may instead be formed of other non-conductive material. A plastic tip 520 may be used to avoid marring of the connector insert and corresponding connector receptacle and to preserve their appearance over time. Plastic tip 520 may also be durable as compared to metallic or other types of front ends. Plastic tip 520 may be a front end of a molded portion or housing 524 in the connector insert.

[0066] A gap 530 between plastic tip 520 and shield 510 may exist. This arrangement may allow light from opening 550 to pass through opening 522, which may be present for ground contacts 560 to electrically connect to shield 510, through gap 530 where it may be visible to a user. Accordingly, plastic tip 520 may include a ledge 540 to block light that may otherwise pass through gap 530. Specifically, ledge 540 may be present between edges 544 and 542. Ledge 540

may effectively cover an end of gap 530, thereby preventing light leakage. Put another way, opening 522 may be formed such that it has a leading edge 542 that is behind gap 530 in the direction away from the front opening of the connector insert.

[0067] In other embodiments of the present invention, a force may be applied to the remote end of shield 510 to reduce the gap 530 between shield 510 and plastic tip 520. An example is shown in the following figure.

[0068] FIG. 6 illustrates a portion of a connector insert according to an embodiment of the present invention. In this example, shield 510 may be adjacent to or in close proximity to plastic tip 520. This close proximity may be caused by a force being applied to shield 510. Specifically, during assembly, arms 620 may be compressed or folded in closer to each other such that shield 510 may be slid over plastic housing 610. When shield 510 reaches plastic tip 520, arms 620 may be released, whereupon they may push out and against an end of shield 510. That is, arms 620 may be biased outward such that when they are released, they push out and against a rear portion of shield 510. Specifically, a surface 630 of arms 620 may be ramped or sloped such that a force is applied to shield 510 moving it adjacent to or in close proximity to plastic tip 520. A molded piece 650 may be inserted through a back end of shield 510 in order to force arms 620 outward, thereby holding shield 510 in place against plastic tip 520.

[0069] In this example, tape piece 670 may be included. Tape piece 670 may help to prevent signal contacts in the connector insert from contacting shield 510. Tape piece 670 may be sloped as shown so that it is not caught on the leading edge of shield 510 as shield 510 slides over plastic housing 610 during assembly.

[0070] Once this connector insertion portion is complete, a housing and cable may be attached to a rear portion of the assembly. This may be done in a way that avoids or reduces various problems in the manufacturing process. An example is shown in the following figure.

[0071] FIG. 7 illustrates a portion of a connector insert according to an embodiment of the present invention. In this example, cable 780 may pass through cap 770. Cap 770 may be covered or partially covered by strain relief 760. Conductors 740 in cable 780 may terminate on printed circuit board 730 at contacts 750. Traces (not shown) on printed circuit board 730 may connect contacts 750 to contacts in the connector insert. The printed circuit board 730 of a connector insert may be housed in housing 720.

[0072] FIG. 8 illustrates a cutaway view of a portion of a connector insert according to an embodiment of the present invention. Again, conductors 740 may terminate at contacts 750 on printed circuit board 730. Braiding 810 of cable 780 may be folded back onto itself and crimped by cap 770. An example of how this crimping may be done is shown in the following figure.

[0073] FIG. 9 illustrates a structure for crimping a cap around an end of a cable according to an embodiment of the present invention. In this example, four tool die pieces 900 may be used. These die pieces may be pushed inwards until gap 910 is reduced to a small or zero distance between each tool die piece 900. This may crimp cap 770 around the braiding 6410 of cable 780. The tool die piece 900 may include various points or peaks, such as 920 and 930. These points may effectively wrinkle or jog the perimeter of the cap, thereby reducing the dimensions of a cross-section of

cable 780. This may improve the flow of plastic while forming strain relief 760 around cable 780.

[0074] Embodiments of the present invention may provide connector inserts having improved ground contacts and retention spring features. An example is shown in the following figure.

[0075] FIG. 10 illustrates an exploded view of a connector insert according to an embodiment of the present invention. This connector insert may include a shield 1010 around housing 1020. A number of contacts 1030 may be placed in housing 1020. Specifically, contacts 1030 may be located in slots 1028 and top and bottom sides of housing 1020. Secondary housing 1032 may secure contacts 1030 together as a unit. Side retention springs 1050 may be located in side openings 1022 in housing 1020. Ground contacts 1040 may be located at a front of the connector insert between an opening of a connector insert and contacts 1030. Ground contacts 1040 may be located in grooves 1024 in housing 1020. Insulating layers 1060 may be used to prevent contacts 1030 from contacting shield 1010. Insulating layers 1060 may be pieces of Kapton tape or other insulating material. Shield 1010 may include tabs 1012 which may engage notch 1026 when housing 1020 is inserted into shield 1010 during manufacturing.

[0076] FIG. 11 illustrates a retention spring that may be used in a connector insert according to an embodiment of the present invention. Retention springs 1050 may include a contacting portion 1110. Contacting portion 1110 may engage a notch in a tongue in a connector receptacle when a connector insert is inserted into the connector receptacle. Retention spring 1050 may further include dimple 1120, though in other embodiments of the present invention, dimple 1120 may be absent. Dimple 1120, if present, or the surface of retention spring 1050 if not, may engage in inside of shield 1010 when the connector insert is inserted into a connector receptacle. In other embodiments of the present invention, dimple 1120, if present, or the surface of retention spring 1050 if not, may contact and inside of shield 1010 before the connector insert is inserted into a connector receptacle. Retention spring 1050 may further include prongs 1130. Prongs 1130 may secure retention spring 1050 to a housing of the connector insert.

[0077] Retention spring 1050 may have an overall first length 1150. Retention spring 1050 may also include a deflection arm 1160. The deflection arm 1160 may extend from dimple 1120, if present, to contacting portion 1110. In other embodiments of the present invention, the deflection arm 1160 may extend from a location where the retention spring 1050 contacts the shield 1010 to the contacting portion 1110. The deflection arm 1160 may consume a majority of the length of retention spring 1050. That is, the length of the deflection arm 1160 may be more than one half of the length 1150 of the total retention spring. In this way, stresses may be spread out over the retention spring 1050 during insertion. This may help to avoid a concentration of stress that could otherwise cause a cold working failure or cracking in the retention spring 1050. Specifically, a surface or dimple 1120 (if present) of retention spring 1050 may contact a surface, such as an inside of shield 1010, when the connector insert starts to be inserted into a connector receptacle. Force or stress may concentrate at this point, but the retention spring may be made thicker or wider in or more directions near dimple 1120 (if present) to support the stress. As the insert continues to be inserted, the deflection arm may

deflect, absorbing further stresses over a long portion of the retention spring **1050**. Particularly where no dimple **1120** is present, the contact area between retention spring **1050** and shield **1010** or other surface may “rock” or move along the length of the retention spring **1050** (towards the contacting portion **1110**), again helping to distribute the points of high stress compensation. This configuration may provide a retention spring that is hard enough to provide a good retention force but not fail due to cold working. These retention springs may be formed in various ways. For example, they may be forged, stamped, metal-injection-molded, or formed in other ways. Further details on these retention springs may be found in co-pending U.S. patent application Ser. 14/543,748, filed Nov. 17, 2014 (Attorney Docket number 90911-P21848US1), which is incorporated by reference.

[0078] FIG. 12 illustrates a top cut-away view of a connector insert according to an embodiment of the present invention. This connector insert may include a number of contacts **1030**. Ground contacts **1040** may be located between contacts **1030** and a front opening and housing **1020**. Retention springs **1050** may be located along outside edges of the connector insert. Retention springs **1050** may include contacting portions **1110**. Contacting portion **1110** may engage and fit in a notch on sides of a tongue of a connector receptacle when the connector insert is inserted into the connector receptacle. Retention springs **1050** may further include dimple **1120**, though dimple **1120** may be absent in various embodiments of the present invention. Dimple **1120**, if present, may engage an inside of shield **1010** when the connector insert is inserted into a connector receptacle, or before and while the connector insert is inserted into a connector receptacle. If dimple **1120** is not present, the retention spring surface itself may engage an inside of shield **1010** when the connector insert is inserted into a connector receptacle, or before and while the connector insert is inserted into a connector receptacle. Retention springs **1050** may include prongs **1130** for securing retention springs **1050** to the insert housing. An outside housing **1210** may surround a rear portion of the connector insert. Housing **1210** may be grasped by a user during the insertion and extraction of the connector insert into and out of a connector receptacle.

[0079] FIG. 13 illustrates a front view of a connector insert according to an embodiment of the present invention. Again, the connector insert may have a shield **1010** around housing **1020**. Retention springs **1050** may be located in openings and sides of housing **1020**. Ground contacts **1040** may be located near a front opening of the connector insert. A housing **1210** may surround a rear portion of a connector insert.

[0080] The connector insert may include a front lip defining a front opening. This lip may have an inside portion formed of housing **1020** and an outside portion formed of shield **1010**. By providing an inside portion of the lip formed of a non-conductive material, shield **1010** is less likely to engage and short to contacts on a tongue of a connector receptacle while the connector insert is being inserted into the connector receptacle. To further protect against shorting receptacle contacts, the housing **1020** may be arranged to be either aligned with or extending beyond the shield **1010**. Having at least a portion of the lip formed of shield **1010** may help to improve the strength of the leading edge of the connector.

[0081] As shown in FIG. 2 above, the connector insert may include front ground contacts for engaging ground contacts on a connector receptacle tongue when the connector insert is inserted into the connector receptacle. It may be desirable that these ground contacts do not increase an overall length of an insert portion of a connector insert dramatically. An example of such a ground contact is shown in the following figure. The operation of such a ground contact was shown above in reference to ground contact **230** in FIG. 2. Other examples and further information regarding the operation of these ground contacts may be found in co-pending U.S. patent application Ser. No. 14/543,717, filed Nov. 17, 2014 (Attorney Docket number 90911-P21847US2), which is incorporated by reference.

[0082] FIG. 14 illustrates a connector insert portion and a ground contact according to an embodiment of the present invention. This connector insert may include a housing **1020** supporting retention springs **1050** and ground contacts **1040**. Ground contacts **440** may be located in groove **1024** near a front of housing **1020**. Ground contacts **1040** may reduce an overall length of an insert portion of a connector insert by wrapping laterally around approximately half the circumference of housing **1020**. By wrapping laterally in this way, the increase in the overall length of the insert portion caused by the inclusion of the ground contacts **1040** is limited.

[0083] Ground contacts **1040** may include contacting portions **1440**, which may be joined by crosspiece **1430**. Crosspiece **1430** may be held in place by supporting structures **1410**. Supporting structures **1410** may include tabs **1420** for holding ground contacts **1040** securely in place in groove **1024** in housing **1020**. Ground contacts **1040** may also connect to an inside of shield **1010**.

[0084] Again, a tape or other insulating layer **1060** may be placed between contacts **1030** and shield **1010** to prevent contacts **1030** from contacting shield **1010**. Insulating or tape layer **1060** may be attached to housing **1020**. When housing **1020** is inserted into shield **1010**, care should be taken to avoid having shield **1010** strip away insulating or tape layer **1060**. Accordingly, embodiments of the present invention may arrange housing **1020** to protect the tape or insulating layer **1060** during insertion of housing **1020** into shield **1010**. An example is shown in the following figure.

[0085] FIG. 15 illustrates steps in the manufacturing of a connector insert according to an embodiment of the present invention. In this figure, housing **1020** is shown being inserted into shield **1010**. Insulating or tape layer **1060** may be located on top and bottom surfaces of housing **1020**. Housing **1020** may include notch portion **1510**. Notch portion **1510** may provide a space for tape layer **1060** to be placed such that it is not peeled away by shield **1010** when housing **1020** is inserted into shield **1010**.

[0086] Again, the connector insert may include a front lip having outside portion formed by shield **1010** and an inside portion formed by housing **1020**. Accordingly, shield **1010** may include a surface **1018** to engage surface **1029** of housing **1080**. This connector insert may also include ground contact **1040**.

[0087] In various embodiments of the present invention, signal contacts **1030** may be pre-biased in a way that results in a force being exerted at the opening of a connector insert. This force may be in a direction that tends to close the connector insert opening. This may result in a connector receptacle tongue being damaged during the insertion of the connector insert into a connector receptacle. Accordingly,

embodiments of the present invention may provide manufacturing steps to avoid or mitigate this problem. An example is shown in the following figures.

[0088] FIG. 16 illustrates forces being exerted at a connector insert opening according to an embodiment of the present invention. Contacts 1030 may be located in housing 1020. Contacts 1030 may be pre-biased to exert a force on contacts on a tongue of a connector receptacle when the connector insert is inserted into the connector receptacle. This pre-bias may cause contacts 1030 to exert a force on housing 1020. This force may act to close a front opening of the connector insert. Accordingly, embodiments of the present invention may provide an end cap that may be inserted into the front opening of a connector insert during manufacturing. An example is shown in the following figure.

[0089] FIGS. 17A-17B illustrate an end cap being inserted into an opening of a connector insert according to an embodiment of the present invention. End cap 1720 may have a handle portion 1722 that may be grasped by an operator during assembly. The operation of end cap 1720 is shown in the following figure.

[0090] FIG. 18 illustrates the operation of an end cap that may be employed during manufacturing of a connector insert according to an embodiment of the present invention. State A illustrates an opening 1712 of a connector insert. Opening 1712 may have top and bottom sides biased outwardly to create compensate for forces that will be applied by contacts 1030 as shown above. Similarly, end cap 1720 may have top and bottom sides that are bowed or biased outwardly as well, as shown in stage B. End cap 1720 may be inserted into opening 1712 in stage C. At this time, the connector insert may be subjected to a high-temperature process, such as a reflow process. Ordinarily, this heating could cause the opening to droop and close. Instead, the outward shape may provide an arch of support to maintain the shape of the opening and keep it from closing. At stage D, end cap 1720 may be removed. After some time, stage E may be reached. At this stage, the top and bottom sides of opening 1712 may remain either straight or partially outwardly bowed.

[0091] FIG. 19 illustrates another connector insert according to an embodiment of the present invention. Connector insert 1900 may include two contact assemblies 1910. Contact assemblies 1910 may each include a number of contacts 1920 supported by housing 1930. Contacts 1920 may include contacting portions 1922. Contacting portions 1922 may form electrical connections with contacts on a tongue of a corresponding connector receptacle when connector insert 1900 is mated with the corresponding connector receptacle. Contacts 1920 may further include tail portions 1924. Tail portions 1924 may be soldered or otherwise connected to a board or conductors (not shown) in connector insert 1900. Housing 1930 may include interlocking features including tabs 1932 and opening or holes 1934. Specifically, tab 1932 on lower contact assembly 1910 may fit into an opening or hole 1934 in housing 1930 of an upper contact assembly 1910. Similarly, tab 1932 on an upper contact assembly 1910 may fit into an opening or hole 1934 in housing 1930 of a lower contact assembly 1910. Tabs 1932 may include crush ribs to securely engage opening or hole 1934.

[0092] Connector insert 1900 may further include a central ground plane 1940. Central ground plane 1940 may be plated with nickel to reduce stray and induced currents in

central ground plane 1940. Central ground plane 1940 may include openings 1942 to allow passage of tabs 1932. Central ground plane 1940 may also include articulating arms 1944. Articulating arms 1944 may be soldered or laser welded at points 1946 to retention springs 1950. Retention springs 1950 may include contacting portions 1952. Contacting portions 1952 may engage notches on sides of a tongue of a corresponding connector receptacle. Retention springs 1950 may further include dimples 1954. Dimples 1954 may engage an inside surface of shield 1990. Retention springs 1950 may further include clasp 1956. Clasp 1956 may hold a printed circuit board or other appropriate substrate (not shown) located in connector insert 1900.

[0093] Once assembled, the contact assemblies 1910, central ground plane 1940, and retention springs 1950 may be inserted into housing 1960. Housing 1960 may include side slots 1962 for retention springs 1950. Side slots 1962 may include openings 1964 for contacting portions 1952 of retention springs 1950. An isolation layer 1970 may electrically isolate contacts 1920 from an inside surface of shield 1990. A front portion of housing 1960 may include a central passage 1961 defining a front opening. Front portion of housing 1960 may further include a channel or guide 1966. Channel or guide 1966 may include openings 1968. Channel or guide 1966 may further include a right-angle portion 1967.

[0094] Connector insert 1900 may further include electromagnetic or EMI springs 1980. (The term EMI springs may also refer more generally to ground contacts, as in the examples above.) EMI springs 1980 may include crossbars 1981 arranged in a consecutive fashion. These consecutive crossbars 1981 may be formed separately and joined or they may be formed as a single piece. For example, four crossbars 1981 may be used to form EMI springs 1980, though other numbers of crossbars may be used in other embodiments of the present invention. Ground contacts 1982 may be located at junctions of crossbars 1981 and may be accessible through openings 1968. EMI springs 1980 may further include shield contacts 1984, which may contact an inside of shield 1990. Shield contacts 1984 may push on EMI springs 1980 thereby helping to keep EMI springs 1980 in place. EMI springs 1980 may include feet 1986, which may fit in right-angle portions 1967 of channel or guide 1966.

[0095] The housing assembly including housing 1960, contact assemblies 1910, central ground plane 1940, and retention springs 1950, may be inserted into shell or shield 1990. Shield 1990 may be arranged to fit in a corresponding connector receptacle (not shown.) Shield 1990 may include a front opening 1992 to accept a tongue of a corresponding connector receptacle. Further details of this assembly process are shown below.

[0096] FIG. 20 illustrates a contact assembly for a connector insert according to an embodiment of the present invention. Housing 1930 may be inserted molded around portions of contacts 1920 to form contact assembly 1910. Contacts 1920 may include contacting portions 1922. Contacting portions 1922 may form electrical connections with corresponding contacts on a tongue of a connector receptacle (not shown.) Contacts 1920 may further include tail portions 1924. Tail portions 1924 may be soldered or otherwise connected or attached to a board or other appropriate substrate (not shown) in connector insert 1900. Housing 1930 may include tab 1932 and opening or hole 1934. Tab 1932 may pass through an opening 1942 and central

ground plane 1940 and into a corresponding opening or hole 1934 on a second contact assembly 1910 (as shown in FIG. 19.) Tab 1932 on that connector assembly may pass through a second opening 1942 in central ground plane 1940 and into opening or hole 1934.

[0097] As shown in FIG. 19, these and other embodiments of the present invention may provide retention springs 1950 for connector insert 1900, where retention springs 1950 are preloaded. Specifically, retention springs 1950 may be attached to articulating arms 1944 extending from central ground plane 1940. After attachment, retention springs 1950 may have a greater spacing between contacting portions 1952 than necessary. As retention springs 1950 are inserted into shield 1990 of connector insert 1900, a compressive force may be applied to sides of retention springs 1950 such that articulating arms 1944 are angled towards the central ground plane 1940 and contacting portions 1952 are driven closer together. This compression may also provide a preloading on retention springs 1950. When a connector receptacle tongue is inserted into connector insert 1900, a user may have to overcome the preloading of retention springs 1950 before the tongue may continue to be inserted. This preloading may provide connector insert 1900 with a more consistent insertion profile, more stable normal forces, and a greater durability. It may simplify manufacturing of retention springs 1950, allowing the use of softer materials that may be stamped instead of being forged. These retention springs 1950 may have a more uniform thickness along their length, since the insertion profile of connector insert 1900 is not being primarily determined by the shape of the retention springs. Retention springs 1950 may be laser welded to articulating arms 1944 at several locations. This may provide an attachment between retention springs 1950 and central ground plane 1940 that may withstand the application of force during assembly as well as the preloading force. The attached retention springs 1950 and central ground plane 1940 may form a unit that is easily mated to connector insert housing 1960 to simplify assembly. Examples of these retention springs 1950 are shown in the following figures.

[0098] FIG. 21 illustrates a central ground plane and retention springs for a connector insert according to an embodiment of the present invention. Central ground plane 1940 may include openings 1942 to allow passage of tabs 1932. Central ground plane 1940 may further include articulating arms 1944. Articulating arms 1944 may be soldered or laser welded to retention springs 1950 at locations or points 1946. Retention springs 1950 may include dimples 1954. Dimples 1954 may provide a contacting point with an inside of shield 1990, as shown in FIG. 19. Retention springs 1950 may further include contacting portions 1952. Contacting portions 1952 may fit in openings 1964 of housing 1960 as shown in FIG. 19. Contacting portions 1952 may engage notches on a side of a connector receptacle tongue (not shown) when mated with connector insert 1900.

[0099] FIG. 22 illustrates a portion of the assembly of a connector insert according to an embodiment of the present invention. In this example, retention springs 1950 may be attached to articulating arms 1944 of central ground plane 1940. Again, retention springs 1950 may be splayed such that their contacting portions 1952 are spaced apart. This may allow space between retention springs 1950 to allow contact assemblies 1910 and central ground plane 1940 to be assembled together. Specifically, tabs 1932 may pass through openings 1942 in central ground plane 1940 to fit in

opposing openings or holes 1934 in housing 1930 of contact assembly 1910. Contact assemblies 1910 may include contacts 1920 partially housed by insert molded housings 1930. Tabs 1932 may include crush ribs to secure housings 1930 to each other.

[0100] FIG. 23 illustrates a preloading of retention springs according to an embodiment of the present invention. After retention springs 1950 have been attached to articulating arms 1944 of central ground plane 1940, contacting portions 1952 of retention springs 1950 may be separated by a distance A. This assembly may then be inserted into shield 1990, as shown in FIG. 19. Dimples 1954 may engage an inside surface of shield 1990 and retention springs 1950 may be pushed, for example with a tool (not shown), into the shield 1990 such that that dimples 1954 may be pushed inwards towards each other. This may push articulating arms 1944 downward as shown toward the bulk portion of central ground plane 1940. This compressive force may reduce a distance between contacting portions 1952 to a distance B, where B is less than A. This compressive force may provide a preload on retention springs 1950. Specifically, as a tongue is inserted into connector insert 1900, the preload force provided by the compression at dimples 1954 may need to be overcome by a user before contacting portions 1952 can separate to allow further insertion of the tongue.

[0101] This preload force may improve the consistency of the insertion profile of connector insert 1900. This may simplify the design and manufacturing of retention springs 1950, since the preload force and not the shape of retention springs 1950 is primarily responsible for determining the insertion profile. This may also lead to improved durability of connector insert 1900.

[0102] FIG. 24 illustrates views of retention springs according to an embodiment of the present invention. Retention springs 1950 may include contacting portions 1952 and dimples 1954. Retention springs 1950 may fit in side slots 1962 in housing 1960. Retention spring 1950 may be laser or spot welded to central ground plane 1940 at points 1946.

[0103] FIGS. 25-26 illustrate further views of retention springs according to an embodiment of the present invention. Retention springs 1950 may include contacting portions 1952, dimples 1954, openings 1953, and clasp 1956. Clasp 1956 may securely hold, and may be soldered to, a board or other substrate (not shown) in connector insert 1900. Dimple 1954 may engage an inside surface of shield 1990, as shown in FIG. 19. Opening 1953 may provide a passage for ends of articulating arms 1944 of central ground plane 1940, as shown in FIG. 23. Contacting portions 1952 may engage notches on a side of a tongue of a corresponding connector receptacle (not shown.)

[0104] These and other embodiments of the present invention may provide ground contacts 1982 near a front opening of connector insert 1900. These ground contacts 1982 may be included on electromagnetic interference (EMI) springs 1980. These EMI springs 1980 may include four or other numbers of continuous crossbars 1981. These consecutive crossbars 1981 may be formed separately and joined or they may be formed as a single piece. Ground contacts 1982 may be located at junctions of crossbars 1981. Attaching ground contacts 1982 to crossbars 1981 themselves may reduce an amount of housing that may need to be removed to make space for the EMI springs. This may allow the housing to have a greater thickness, which may result in a reduced amount of warpage at a front opening of connector insert

1900. The ground contacts may be exposed at openings **1968** in housing **1960** for connector insert **1900**. Crossbars **1981** may be located in channel or guide **1966** in housing **1960**, where channel or guide **1966** extends laterally across and near the front of connector insert housing **1960**. These EMI springs **1980** may extend nearly **180** degrees around the opening of the connector insert. The outside crossbars may include feet **1986** that snap or otherwise fit in a right-angle portion **1967** of channel or guide **1966**, where the right-angle portion **1967** extends in a direction orthogonal to the remainder of the channel or guide **1966** and away from the front of connector insert **1900**. Ground contacts **1982** may extend from the crossbars into a central passage **1961** of the connector insert **1900** and may be folded back into central passage **1961**. Ground contacts **1982** may also include lateral extensions **1983** that extend roughly parallel to central passage **1961**. During insertion of a tongue into connector insert **1900**, these lateral extensions **1983** may prevent ground contacts **1982** from being pushed back into connector insert **1900** between shield **1990** and housing **1960**. Shield contacts **1984** may be located between ground contacts **1982**, and may extend from the two center crossbars **1981** away from the central passage **1961** of the connector insert **1900** where they may contact an inside surface of shield **1990** of connector insert **1900**. These shield contacts **1984** may also push against the shield **1990** thereby helping to hold EMI springs **1980** in place. The crossbars **1981** may have a torsion force applied during their assembly into housing **1960**. This, along with the flexibility of the crossbars **1981** and ground contacts **1982**, may help to evenly distribute forces when the ground contacts engage a connector receptacle tongue. By more evenly distributing these forces, the amount of permanent deformation of EMI springs **1980** may be reduced. Also, the force applied to a connector receptacle tongue by ground contacts **1982** may be reduced, thereby reducing wear on the tongue. This force may further be refined by tapering one or more of crossbars **1981** in one or more directions along their length.

[0105] FIG. 27 illustrates a portion of an assembly of a connector insert according to an embodiment of the present invention. In this example, contacts **1920** and retention springs **1950** have been inserted into housing **1960**. EMI springs **1980** may be inserted into channel or guide **1966** in housing **1960**. That completed subassembly may then be inserted into shield **1990**.

[0106] FIG. 28 illustrates a housing for a connector insert according to an embodiment of the present invention. Housing **1960** may include side slots **1962** for retention springs **1950**, as shown in FIG. 19. Side slots **1962** may include openings **1964** for contacting portions **1952** of retention springs **1950**, as shown in FIG. 19. Housing **1960** may include slots **1969** for contacts **1920**, as shown in FIG. 19. A front of housing **1960** may support channel or guide **1966**. Openings **1968** from channel or guide **1966** may extend into central passage **1961**. Opening **1968** may provide a passage for ground contacts **1982**, as shown below in FIG. 30. Channel or guide **1966** may include a right-angle portion **1967**. Feet **1986** of EMI springs **1980** may be inserted into right-angle portions **1967**, as shown in FIG. 19.

[0107] In the example of FIG. 19, during the insertion of a connector receptacle tongue into connector insert **1900**, ground contacts **1982** may be pushed by the tongue towards a rear of connector insert **1900**. Without more, ground contacts **1982** may become wedged between housing **1960**

and shield **1990**. Accordingly, embodiments of the present invention may include a lateral portion of ground contact **1982**, where the lateral portion may be blocked from rearward movement by an interior surface of housing **1960**. An example is shown in the following figure.

[0108] FIG. 29 illustrates a side view of a portion of a connector insert according to an embodiment of the present invention. In this example, a leading edge of shield **1990** may be around housing **1960**. An opening **1968** in housing **1960** may allow access to ground contact **1982**. Ground contact **1982** may further include a lateral extension **1983**. As ground contact **1982** encounters a tongue of a corresponding connector receptacle, ground contact **1982** may be forced upward and rotated into a position shown as **2982**. Ground contact **1982** may further include a lateral extension **1983**. Lateral extension **1983** may encounter a wall or surface **1963** of housing **1960**. Lateral extension **1983** may be prevented from traveling in a rearward direction by wall or surface **1963**. Accordingly, lateral extension **1983** may similarly rotate to a position shown here as **2983**. This may help to prevent ground contact **1982** or other portions of EMI springs **1980** from being pushed between housing **1960** and shield **1990**.

[0109] FIG. 30 illustrates a portion of a connector insert according to an embodiment of the present invention. In this example, EMI spring **1980** may be located in channel or guide **1966**. EMI spring **1980** may include a one or more crossbars **1981**. In this example, four crossbars **1981** may be arranged in a consecutive fashion. Ground contacts **1982** may be located at junctions of crossbars **1981**. Ground contacts **1982** may further include lateral extensions **1983**. The center crossbars **1981** may include shield contacts **1984**, while the outer crossbars **1981** may include feet **1986**.

[0110] Again, EMI springs **1980** may be located in channel or guide **1966**. Ground contacts **1982** may be located in openings **1968** in housing **1960**. Feet **1986** may be located in right-angle portions **1967** of channel or guide **1966**. Shield contacts **1984** may contact an inside surface of shield **1990**, as shown in FIG. 19. Shield contacts **1984** may push against shield **1990**, thereby helping maintain EMI springs **1980** in place. In this example, EMI springs **1980** may wrap around approximately one half of the circumference of housing **1960**.

[0111] FIGS. 31-32 illustrate EMI springs according to an embodiment of the present invention. EMI springs **1980** may include ground contacts **1982** at junctions of crossbars **1981**. These consecutive crossbars **1981** may be formed separately and joined or they may be formed as a single piece. EMI springs **1980** may include four crossbars **1981** arranged in a consecutive fashion, though other numbers of crossbars, such as two, three, five or other numbers may be used, and they may be formed separately and joined or they may be formed as a single piece. Center crossbars **1981** may include shield contacts **1984**. Outer crossbars **1981** may include feet **1986**.

[0112] A torsion or twisting force may be applied to EMI springs **1980**. This torsion force, along with the distribution of ground contacts **1982** along crossbars **1981**, may distribute forces applied to EMI springs **1980** during insertion of a connector receptacle tongue (not shown) into connector insert **1900**. Specifically, the torsion force may be applied in a direction to push ground contacts **1982** further into openings **1968** in housing **1960**. This may lead to a reduced force from ground contacts **1982** applied to the tongue during

insertion, thereby reducing wear on the connector receptacle. Outer crossbars **1981** may include tapered portions **1989**. These tapered portions may further help to distribute force along the length of EMI springs **1980**.

[0113] In various embodiments of the present invention, contacts and other conductive portions of connector inserts and receptacles may be formed by stamping, metal-injection molding, machining, micro-machining, 3-D printing, forging, or other manufacturing process. The conductive portions may be formed of stainless steel, steel, copper, copper titanium, phosphor bronze, or other material or combination of materials. They may be plated or coated with nickel, gold, or other material. The nonconductive portions may be formed using injection or other molding, 3-D printing, machining, or other manufacturing process. The nonconductive portions may be formed of silicon or silicone, rubber, hard rubber, plastic, nylon, liquid-crystal polymers (LCPs), or other nonconductive material or combination of materials. The printed circuit boards used may be formed of FR-4, BT or other material. Printed circuit boards may be replaced by other substrates, such as flexible circuit boards, in many embodiments of the present invention.

[0114] Embodiments of the present invention may provide connector inserts and receptacles that may be located in, and may connect to, various types of devices, such as portable computing devices, tablet computers, desktop computers, laptops, all-in-one computers, wearable computing devices, cell phones, smart phones, media phones, storage devices, portable media players, navigation systems, monitors, power supplies, adapters, remote control devices, chargers, and other devices. These connector inserts and receptacles may provide pathways for signals that are compliant with various standards such as one of the Universal Serial Bus (USB) standards including USB-C, High-Definition Multimedia Interface (HDMI), Digital Visual Interface (DVI), Ethernet, DisplayPort, Thunderbolt, Lightning, Joint Test Action Group (JTAG), test-access-port (TAP), Directed Automated Random Testing (DART), universal asynchronous receiver/transmitters (UARTs), clock signals, power signals, and other types of standard, non-standard, and proprietary interfaces and combinations thereof that have been developed, are being developed, or will be developed in the future. Other embodiments of the present invention may provide connector inserts and receptacles that may be used to provide a reduced set of functions for one or more of these standards. In various embodiments of the present invention, these interconnect paths provided by these connector inserts and receptacles may be used to convey power, ground, signals, test points, and other voltage, current, data, or other information.

[0115] The above description of embodiments of the invention has been presented for the purposes of illustration and description. It is not intended to be exhaustive or to limit the invention to the precise form described, and many modifications and variations are possible in light of the teaching above. The embodiments were chosen and described in order to best explain the principles of the invention and its practical applications to thereby enable others skilled in the art to best utilize the invention in various embodiments and with various modifications as are suited to the particular use contemplated. Thus, it will be appreciated that the invention is intended to cover all modifications and equivalents within the scope of the following claims.

What is claimed is:

1. A connector insert comprising:

- a housing having front opening, a first side opening along a right side, a second side opening along a left side, a first plurality of slots along a top side, and a second plurality of slots along a bottom side;
- a first plurality of contacts in the first plurality of slots in the housing;
- a second plurality of contacts in the second plurality of slots in the housing;
- a first retention spring in the first side opening in the housing, the first retention spring having a first length and including a contacting portion at a first end to engage a notch on a tongue of a connector receptacle;
- a second retention spring in the second side opening in the housing, the second retention spring having the first length and including a contacting portion at a first end to engage a notch on a tongue of a connector receptacle;
- a first ground contact between the front opening of the housing and the first plurality of contacts;
- a second ground contact between the front opening of the housing and the second plurality of contacts; and
- a shield over the housing, the first retention spring, and the second retention spring, the shield contacting the first retention spring and the second retention spring when the connector insert is inserted into a connector receptacle,

wherein the first ground contact and the second ground contact each include a plurality of contacting portions joined by a cross beam, the cross beam attached to a first lateral support structure and a second lateral support structure, wherein the first lateral support structure and a second lateral support structure wrap around approximately one-half of the circumference of the housing in the lateral direction.

2. The connector insert of claim 1 wherein the shield contacts the first retention spring and the second retention spring before the connector insert is inserted into a connector receptacle.

3. The connector insert of claim 1 wherein the first retention spring further comprises a dimple, and a portion of the first retention spring from the dimple to the contacting portion forms a deflection arm that deflects as the connector insert is inserted into a connector receptacle.

4. The connector insert of claim 3 wherein the deflection arm has a length that is a majority of the first length.

5. The connector insert of claim 3 wherein the deflection arm has a length that is greater than one-half of the first length.

6. The connector insert of claim 1 further comprising a first insulating layer between the first plurality of contacts and the shield and a second insulating layer between the second plurality of contacts and the shield.

7. The connector insert of claim 6 wherein the first insulating layer and the second insulating layer are pieces of tape.

8. The connector insert of claim 1 wherein the connector insert has a front lip around the front opening, wherein an inside portion of the front lip is formed by the housing and the outside portion of the front lip is formed by the shield.

9. A connector insert comprising:

- a housing having front opening, a first side opening along a right side, a second side opening along a left side, a

first plurality of slots along a top side, and a second plurality of slots along a bottom side;
 a first plurality of contacts in the first plurality of slots in the housing;
 a second plurality of contacts in the second plurality of slots in the housing;
 a first retention spring in the first side opening in the housing;
 a second retention spring in the second side opening in the housing, wherein the first retention spring and the second retention spring are preloaded;
 a first electromagnetic interference (EMI) spring between the front opening and the first plurality of contacts;
 a second EMI spring between the front opening and the second plurality of contacts, wherein the first EMI spring and the second EMI spring each include a plurality of ground contacts joined by a plurality of consecutive crossbars; and
 a shield over the housing, the first retention spring, and the second retention spring.

10. The connector insert of claim **9** wherein the first EMI spring and the second EMI spring wrap around approximately one-half of the circumference of the housing in the lateral direction.

11. The connector insert of claim **9** further comprising a first insulating layer between the first plurality of contacts and the shield and a second insulating layer between the second plurality of contacts and the shield.

12. The connector insert of claim **11** wherein the first insulating layer and the second insulating layer are pieces of tape.

13. The connector insert of claim **9** wherein the first retention spring and the second retention spring each has a first length and includes a contacting portion at a first end to engage a notch on a tongue of a connector receptacle, where each retention spring further includes a dimple, the dimple contacting the shield when the connector insert is inserted into a connector receptacle.

14. The connector insert of claim **13** wherein the shield contacts the dimple on the first retention spring and the dimple on the second retention spring before the connector insert is inserted into a connector receptacle.

15. The connector insert of claim **9** wherein the connector insert has a front lip around the front opening, wherein an inside portion of the front lip is formed by the housing and the outside portion of the front lip is formed by the shield.

16. A connector insert comprising:

a housing having front opening, a first side opening along a right side, a second side opening along a left side, a

first plurality of slots along a top side, and a second plurality of slots along a bottom side;
 a first contact assembly comprising:
 a first plurality of contacts in the first plurality of slots in the housing; and
 an insert molded housing around portions of the first plurality of contacts;
 a second contact assembly comprising:
 a second plurality of contacts in the second plurality of slots in the housing; and
 an insert molded housing around portions of the second plurality of contacts;
 a central ground plane between the first contact assembly and the second contact assembly, the central ground plane comprising a first articulating arm and a second articulating arm,
 a first retention spring attached to the first articulating arm and located in the first side opening in the housing;
 a second retention spring attached to the second articulating arm and located in the second side opening in the housing;
 a first electromagnetic interference (EMI) spring between the front opening and the first plurality of contacts;
 a second EMI spring between the front opening and the second plurality of contacts, wherein the first and second EMI springs each include a plurality of ground contacts joined by a plurality of consecutive crossbars; and
 a shield over the housing, the first retention spring, and the second retention spring.

17. The connector insert of claim **16** wherein the first retention spring and the second retention spring are preloaded.

18. The connector insert of claim **16** wherein the first and second EMI springs each comprise a shield contact contacting an inside surface of the shield.

19. The connector insert of claim **16** wherein a tab on the insert molded housing of the first contact assembly passes through a first opening in the central ground plane and into a hole in the insert molded housing of the second contact assembly, and a tab on the insert molded housing of the second contact assembly passes through a second opening in the central ground plane and into a hole in the insert molded housing of the first contact assembly.

20. The connector insert of claim **16** wherein the first EMI spring and the second EMI spring wrap around approximately one-half of the circumference of the housing in the lateral direction.

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